

Grizzly **Industrial, Inc.**®

MODEL G1014Z/G1014ZX COMBINATION SANDER OWNER'S MANUAL

G1014Z



G1014ZX



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
(FOR MODELS MANUFACTURED SINCE 11/07) #BL11448 PRINTED IN TAIWAN

 **WARNING!**

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

 **WARNING!**

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes errors do happen and we apologize for them.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:		Manufacture Date of Your Machine ing this machine: operation. s and respirator. sted/setup and suit before starting.	
Specification:			
Specification:			
Specification:			
Weight:			
<input type="text"/>	Date	<ol style="list-style-type: none">4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.5. DO NOT expose to rain or dampness.6. DO NOT modify this machine in any way.7. DO NOT remove safety guards.8. Never leave machine running unattended.9. DO NOT operate under the influence of drugs or alcohol.10. Maintain machine carefully to prevent accidents.	
<input type="text"/>	Serial Number		
Manufactured for Grizzly in Taiwan			

For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

This combination sander can be used to smooth the faces, edges, or ends of workpieces using the sanding belt or the sanding disc.

The sanding belt can be used in either the horizontal position or vertical position.

The back stop supports workpieces in the horizontal position, and the work table supports workpieces on the sanding disc or the belt when it is in the vertical position.

The work table and miter gauge can be adjusted for the desired angle.



Identification

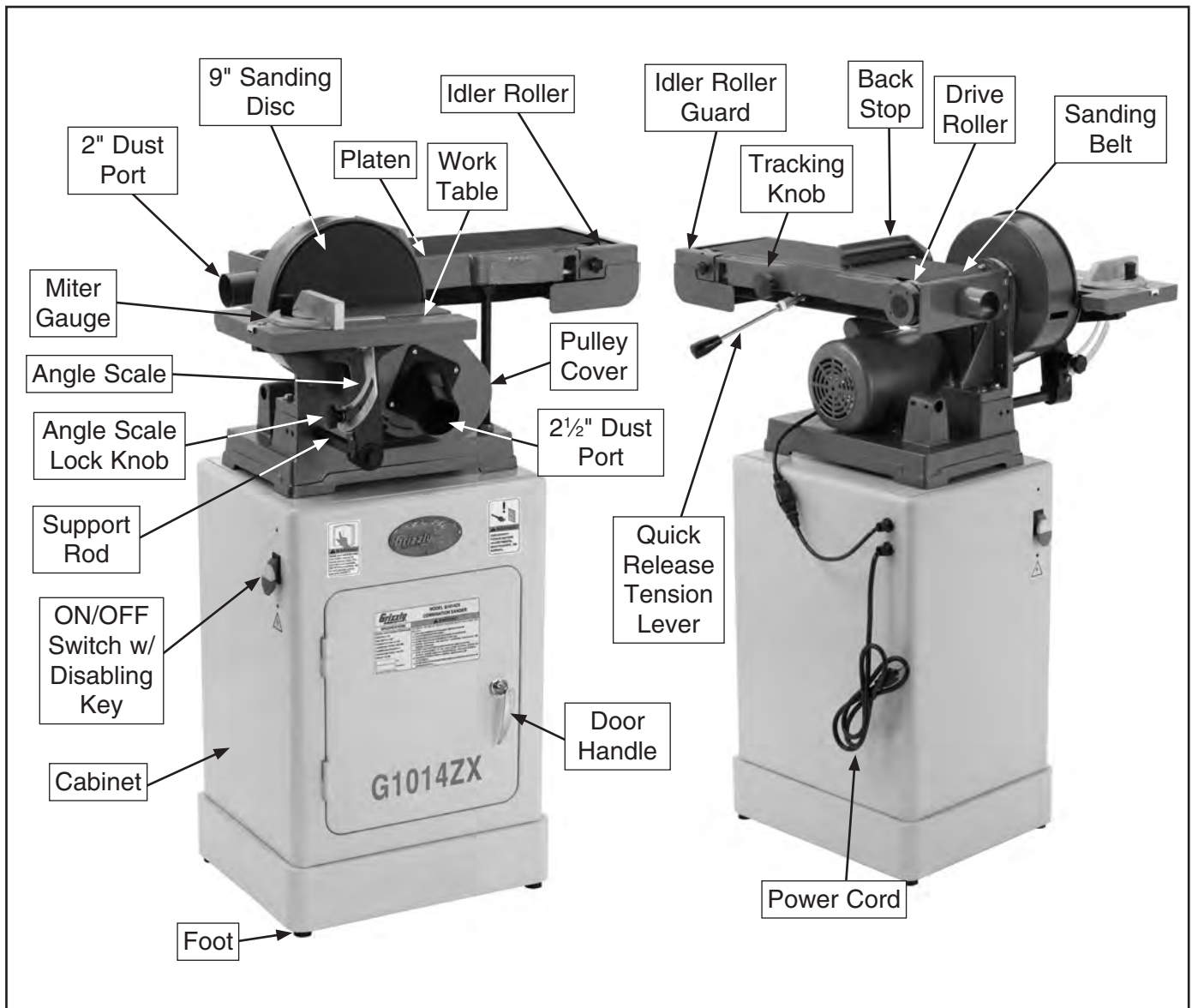


Figure 1. G1014ZX identification.

NOTICE

If you have never used this type of machine or equipment before, **WE STRONGLY RECOMMEND** that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G1014Z COMBINATION SANDER 6" X 48" BELT 9" DISC Z SERIES

Product Dimensions:

Weight..... 117 lbs.
 Length/Width/Height..... 30 x 24 x 56 in.
 Foot Print (Length/Width)..... 23 x 19 in.

Shipping Dimensions:

Type..... Cardboard
 Content..... Machine
 Weight..... 122 lbs.
 Length/Width/Height..... 29 x 19 x 15 in.

Electrical:

Switch..... Safety Key Type
 Switch Voltage..... 110V
 Cord Length..... 6 ft.
 Cord Gauge..... 16 gauge
 Minimum Circuit Size..... 20 amp
 Plug Included..... Yes

Motors:

Main

Type..... TEFC Capacitor Start Induction
 Horsepower..... 3/4 HP
 Voltage..... 110/220V
 Prewired..... 110V
 Phase..... Single
 Amps..... 12/6A
 Speed..... 3450 RPM
 Cycle..... 60 Hz
 Number Of Speeds..... 1
 Power Transfer Belt Drive
 Bearings..... Sealed and Permanently Lubricated

Main Specifications:

Table Info

Table Tilt..... 0 - 45 deg.
 Floor To Table Height..... 35 in.
 Miter Gauge Slot Width..... 3/4 in.
 Miter Gauge Slot Height..... 13/32 in.
 Disc Table Length..... 12-1/4 in.
 Disc Table Width..... 6 in.
 Disc Table Thickness..... 1 in.



Belt Info

Sanding Belt Width.....	6 in.
Sanding Belt Length.....	48 in.
Sanding Belt Speed.....	2300 FPM
Belt Arm Tilt.....	0 - 90 deg.
Height Belt Arm Horizontal.....	40 in.
Height Belt Arm Vertical.....	56 in.
Belt Release.....	Quick Release
Drive Roller Type.....	Aluminum
Drive Roller Length.....	6 in.
Drive Wheel Diameter.....	3-1/2 in.
Idler Roller Type.....	Aluminum
Idler Roller Length.....	6 in.
Idler Roller Diameter.....	3-1/2 in.

Spindle Info

Arbor Size.....	5/8 in.
Total Arbor Length.....	11-1/2 in.

Disc Info

Sanding Disc Diameter.....	9 in.
Sanding Disc Speed.....	3450 RPM

Platen Info

Platen Type.....	Graphite Coated
Platen Length.....	17 in.
Platen Width.....	6-1/4 in.

Construction

Base Construction.....	Cast Iron
Stand Construction.....	Preformed Steel
Table Construction.....	Cast Iron
Frame Construction.....	Cast Iron
Disc Construction.....	Cast Iron
Miter Gauge Construction.....	Die Cast Aluminum/Aluminum Bar
Paint.....	Epoxy

Other

No. Of Dust Ports.....	2
Dust Port Size.....	2, 2-1/2 in.
Mobile Base.....	G7314

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label on Front of Stand, Above Grizzly Nameplate
Awards	Wood Magazine Best Value 1998
Assembly Time	1-1/2 hours

Features:

- 2" Dust Port for Belt and 2-1/2" Dust Port for Disc
- Quick Belt Release
- Work Table Mounts for Use on Disc or Belt
- Single Knob Tracking
- Cast Iron Table
- Graphite Coated Platen
- Sturdy Steel Stand





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G1014ZX COMBINATION SANDER WITH CABINET STAND

Product Dimensions:

Weight..... 148 lbs.
 Length/Width/Height..... 30 x 24 x 56 in.
 Foot Print (Length/Width)..... 15 x 16-1/2 in.

Shipping Dimensions:

Carton #1

Type..... Cardboard
 Content..... Machine
 Weight..... 104 lbs.
 Length/Width/Height..... 19 x 28 x 15 in.

Carton #2

Type..... Cardboard
 Content..... Stand
 Weight..... 52 lbs.
 Length/Width/Height..... 20 x 17 x 28 in.

Electrical:

Switch..... Safety Key Type
 Switch Voltage..... 110V
 Cord Length..... 8-1/2 ft.
 Cord Gauge..... 16 gauge
 Minimum Circuit Size..... 20 amp
 Plug Included..... Yes

Motors:

Main

Type..... TEFC Capacitor Start Induction
 Horsepower..... 3/4 HP
 Voltage..... 110/220V
 Prewired..... 110V
 Phase..... Single
 Amps..... 12/6A
 Speed..... 3450 RPM
 Cycle..... 60 Hz
 Number Of Speeds..... 1
 Power Transfer Belt Drive
 Bearings..... Sealed, Permanently Lubricated



Main Specifications:

Table Info

Table Tilt.....	0 - 45 deg.
Floor To Table Height.....	37-1/2 in.
Miter Gauge Slot Width.....	3/4 in.
Miter Gauge Slot Height.....	13/32 in.
Disc Table Length.....	12-1/4 in.
Disc Table Width.....	6 in.
Disc Table Thickness.....	1 in.

Belt Info

Sanding Belt Width.....	6 in.
Sanding Belt Length.....	48 in.
Sanding Belt Speed.....	2300 FPM
Belt Arm Tilt.....	0 - 90 deg.
Height Belt Arm Horizontal.....	42 in.
Height Belt Arm Vertical.....	58 in.
Belt Release.....	Quick Release
Drive Roller Type.....	Aluminum
Drive Roller Length.....	6 in.
Drive Wheel Diameter.....	3-1/2 in.
Idler Roller Type.....	Aluminum
Idler Roller Length.....	6 in.
Idler Roller Diameter.....	3-1/2 in.

Spindle Info

Arbor Size.....	5/8 in.
Total Arbor Length.....	11-1/2 in.

Disc Info

Sanding Disc Diameter.....	9 in.
Sanding Disc Speed.....	3450 RPM

Platen Info

Platen Type.....	Graphite Coated
Platen Length.....	17 in.
Platen Width.....	6-1/4 in.
Platen Travel.....	0 - 90 deg.

Construction

Base Construction.....	Cast Iron
Stand Construction.....	Sheet Metal
Table Construction.....	Cast Iron
Frame Construction.....	Cast Iron
Disc Construction.....	Cast Iron
Miter Gauge Construction.....	Die Cast Aluminum
Paint.....	Powder Coated

Other

No. Of Dust Ports.....	2
Dust Port Size.....	2, 2-1/2 in.
Mobile Base.....	G8683



Other Specifications:

Country Of OriginTaiwan
Warranty 1 Year
Serial Number Location On the Stand
Assembly Time 30 minutes

Features:

- Solid Cabinet Stand
- Built-in Storage Shelf
- Quick Belt Release Mechanism
- Cast Iron Table, Disc and Body



SECTION 1: SAFETY

WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

- 1. READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Maintain stability and balance at all times.
23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.



WARNING

Safety for Belt and Disc Sanders

- 1. RESPIRATOR AND SAFETY GLASSES.** Always wear a respirator and safety glasses while operating the machine. Dust and chips are created when sanding. Some debris will be ejected, becoming hazards to the eyes and lungs.
- 2. DUST COLLECTION SYSTEM.** Never operate the sander without an adequate dust collection system in place and running.
- 3. CLOTHING.** DO NOT wear loose clothing while operating this machine. Roll up or button sleeves at the cuff to avoid entanglement.
- 4. HAND PROTECTION.** DO NOT place hands near, or in contact with, sanding belt during operation. DO NOT allow fingers to get pinched between the workpiece and the table. This may pull your hand into the machine and cause serious injury!
- 5. MINIMUM STOCK DIMENSIONS.** Do not sand any stock thinner than $\frac{1}{16}$ ", narrower than $\frac{1}{8}$ ", or shorter than 9", to reduce the risk abrasion injury.
- 6. INSPECTING WORKPIECES.** Always inspect workpiece for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.
- 7. FEEDING STOCK.** Firmly grasp the workpiece in both hands and ease it into the machine using light pressure. DO NOT jam the workpiece into the machine during operation. Feed the workpiece against the direction of rotation. DO NOT sand tapered or pointed stock with the point facing the feed direction. Never sand more than one piece of stock at a time.
- 8. UNATTENDED OPERATION.** Never leave the machine running unattended.
- 9. REPLACING SANDPAPER.** Replace sanding paper when it becomes worn. DO NOT operate the sander with a damaged or badly worn sandpaper.
- 10. MAINTENANCE AND ADJUSTMENTS.** Perform machine inspections and maintenance service promptly when called for. Disconnect power before performing maintenance or adjustments on the sander.
- 11. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact Tech Support at (570) 546-9663.

WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



SECTION 2: CIRCUIT REQUIREMENTS

110/220V Operation

!WARNING

Serious personal injury could occur if you connect the machine to power before completing the setup process. **DO NOT** connect the machine to the power until instructed later in this manual.



!WARNING

Electrocution or fire could result if machine is not grounded and installed in compliance with electrical codes. Compliance **MUST** be verified by a qualified electrician!

NOTICE

The Model G1014Z/G1014ZX is prewired for 110V operation. If you plan to operate your machine at 220V, the motor must be rewired (see Page 52).

Full Load Amperage Draw

Amp Draw at 110V (prewired)..... 12 Amps
 Amp Draw at 220V 6 Amps

Power Supply Circuit Requirements

The power supply circuit for your machine **MUST** be grounded and rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

Minimum Circuit Size (110V)..... 15 Amps
 Minimum Circuit Size (220V) 15 Amps

Power Connection Device

The Model G1014Z/G1014ZX comes prewired with a NEMA 5-15 plug for connection to a 110V outlet. If you rewire the motor to 220V, we recommend using the 6-15 plug and receptacle shown in **Figure 2** for 220V.

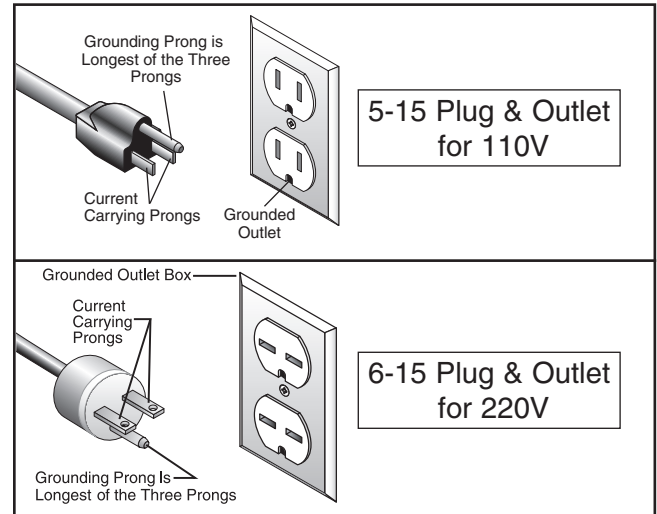


Figure 2. Recommended plug types.

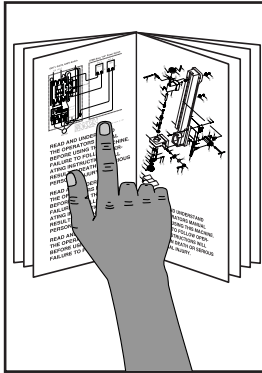
Extension Cords

Using extension cords may reduce the life of the motor. Instead, place the machine near a power source. If you must use an extension cord:

- For 110V, use at least a 14 gauge cord that does not exceed 50 feet in length.
- For 220V, use at least a 14 gauge cord that does not exceed 50 feet in length.
- The extension cord must have a ground wire and plug pin.



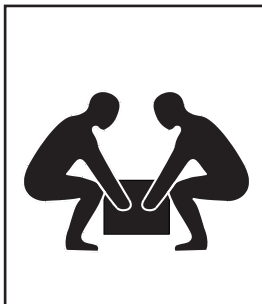
SECTION 3: SETUP



!WARNING
This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING
Wear safety glasses during the entire setup process!



!WARNING
This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser (Page 17)	As Needed
• Disposable Shop Rags.....	As Needed
• Forklift.....	1
• Additional People	1
• Wrench 10mm	1
• Wrench 12mm	1
• Dust Hose 2"	1
• Dust Hose Clamp 2".....	1
• Dust Hose 2½".....	1
• Dust Hose Clamp 2½".....	1
• Flashlight.....	1
• Machinist's Square	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



G1014Z Inventory

The following is a description of the main components shipped with the Model G1014Z. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Box 1: (Figures 3–5)	Qty
A. Sander Unit	1
B. Stand Legs	4
C. Long Lower Braces	2
D. Long Upper Braces	2
E. Short Lower Braces.....	2
F. Short Upper Braces.....	2
G. Sanding Belt 6" x 48"	1
H. Dust Port 2½" (Black).....	1
I. Work Table	1
J. Miter Gauge.....	1
K. Back Stop.....	1
L. Rubber Feet	4
M. Table Support Rod	1
N. Quick Release Lever Stud.....	1
O. Short Lever, 4½" Long.....	1
P. Quick Release Lever Handle	1
Q. Idler Roller	1
R. Idler Roller Guard.....	1
S. Dust Port 2" (Green).....	1
T. Cast Iron Plate.....	1
U. Sanding Disc 9".....	1

Hardware & Tools (not shown)	Qty
• Hex Wrench 4mm.....	1
• Hex Bolts 5/16"-18 x 1" (Feet)	4
• Hex Nuts 5/16"-18 (Feet, Stand)	36
• Flat Washers 5/16" (Feet, Stand).....	40
• Hex Bolts 5/16"-18 x 1½" (Stand & Sander)	4
• Carriage Bolts 5/16"-18 x 1½" (Stand).....	32
• Phillip Head Screws #10-24 x 3/8" (2½" Dust Port).....	4
• Hex Nuts #10-24 (2½" Dust Port).....	4
• Flat Washers #10 (2½" Dust Port).....	4
• Hex Nuts 3/8"-16 (Quick Release Lever)	2

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

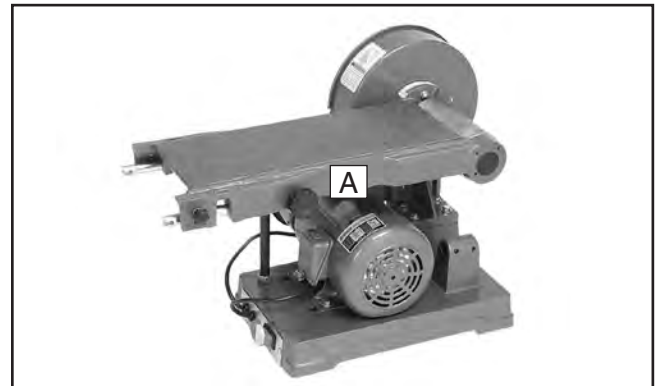


Figure 3. G1014Z sander unit.

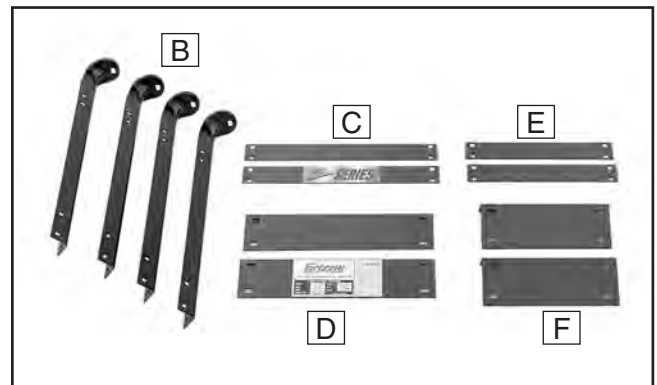


Figure 4. G1014Z stand components.

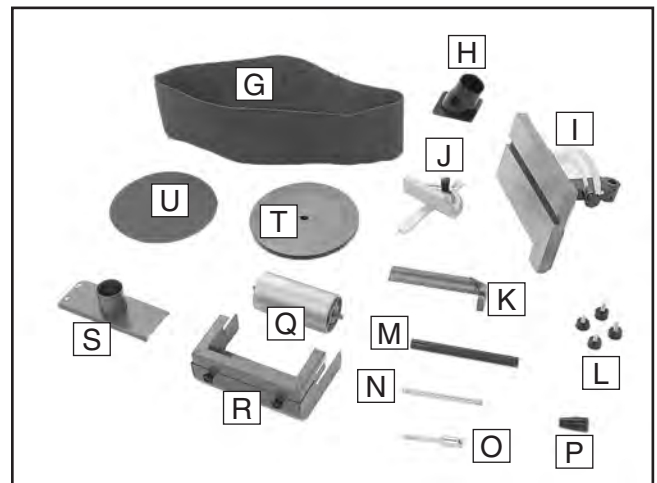



Figure 5. Loose inventory items.



⚠ WARNING

SUFFOCATION HAZARD!

Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.



G1014ZX Inventory

The following is a description of the main components shipped with the Model G1014ZX. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Box 1: (Figure 6)	Qty
A. Sander Unit	1
B. Sanding Belt 6" x 48"	1
C. Dust Port 2½" (Black).....	1
D. Work Table	1
E. Miter Gauge.....	1
F. Back Stop	1
G. Rubber Feet (Cabinet).....	4
H. Quick Release Lever Handle	1
I. Table Support Rod	1
J. Quick Release Lever Stud.....	1
K. Short Lever, 4½" Long.....	1
L. Idler Roller Guard.....	1
M. Idler Roller	1
N. Cast Iron Plate.....	1
O. Sanding Disc 9".....	1
P. Dust Port 2" (Green).....	1

Hardware & Tools (not shown)	Qty
• Hex Wrench 4mm.....	1
• Hex Bolts 5/16"-18 x ½" (Sander & Cabinet) .	4
• Flat Washers 5/16" (Sander & Cabinet).....	4
• Phillip Head Screws #10-24 x ½" (2½" Dust Port).....	4
• Hex Nuts #10-24 (2½" Dust Port).....	4
• Flat Washers #10 (2½" Dust Port).....	4
• Hex Nuts 3/8"-16 (Quick Release Lever)	2

Box 2: (Figure 8)	Qty
A. Cabinet	1
B. Shelf	1

Hardware (not shown)	Qty
• Hex Nuts 5/16"-18 (Cabinet)	4
• Hex Bolts 5/16"-18 x 1" (Cabinet).....	4
• Flat Washers 5/16" (Cabinet)	4

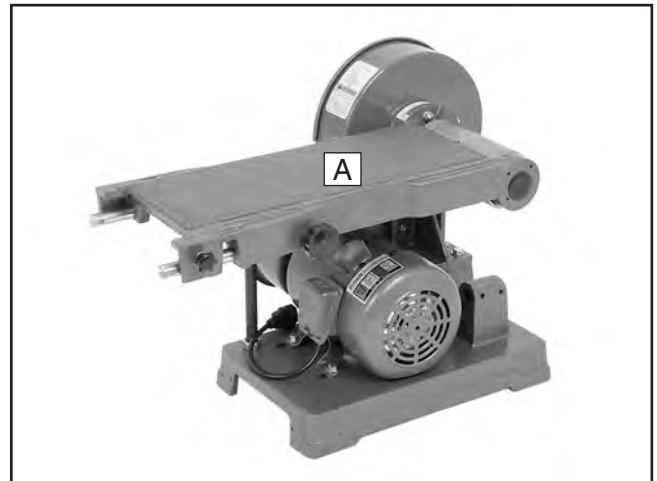


Figure 6. G1014ZX sander unit.

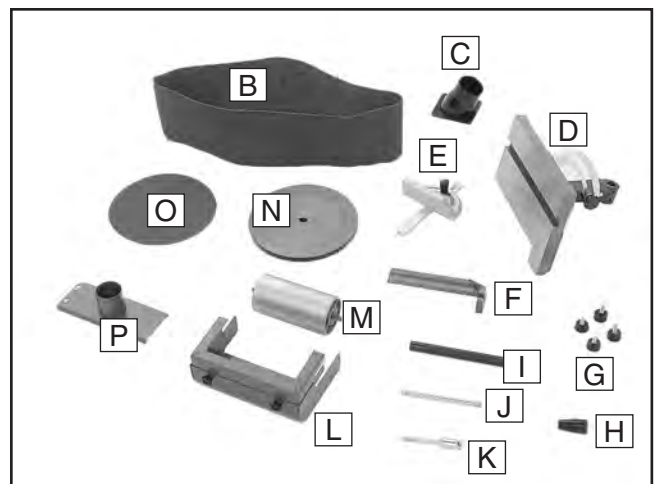


Figure 7. G1014ZX loose inventory items.

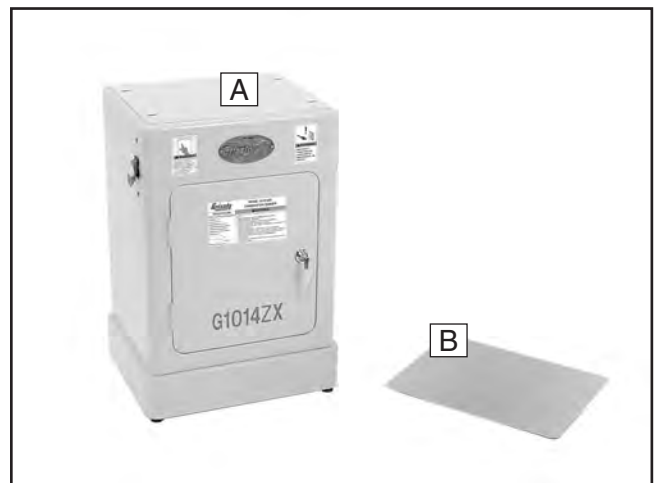


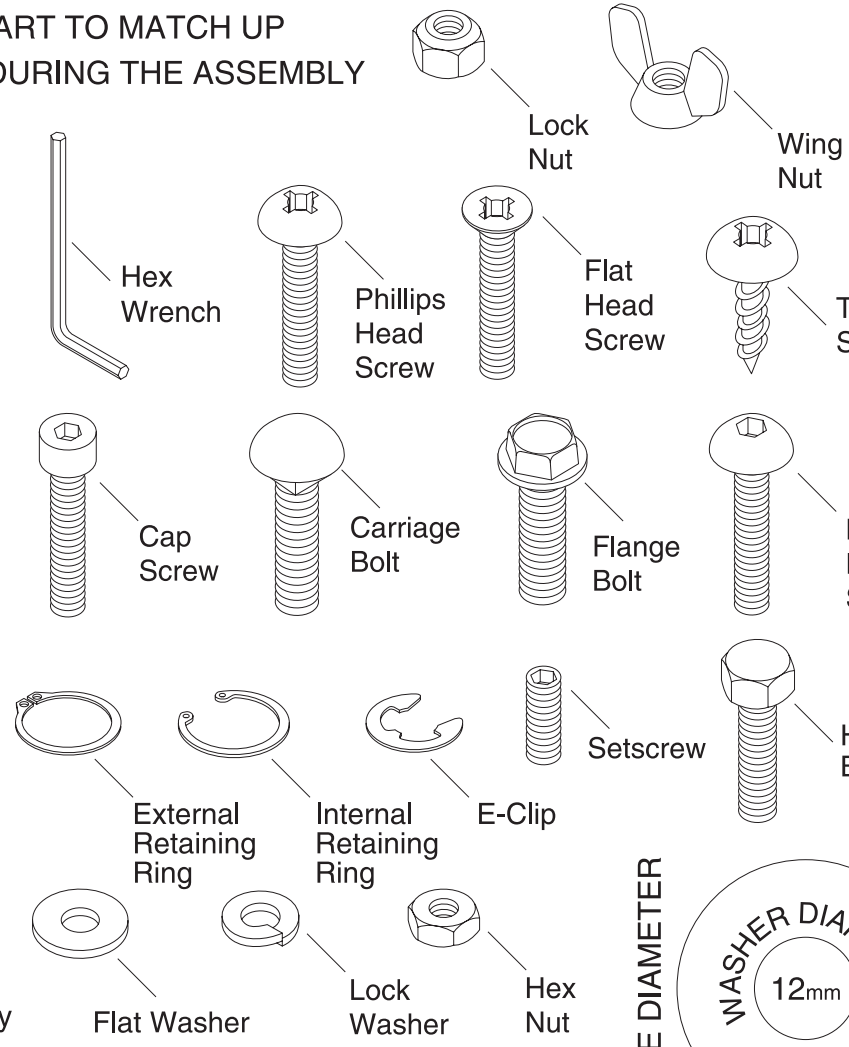
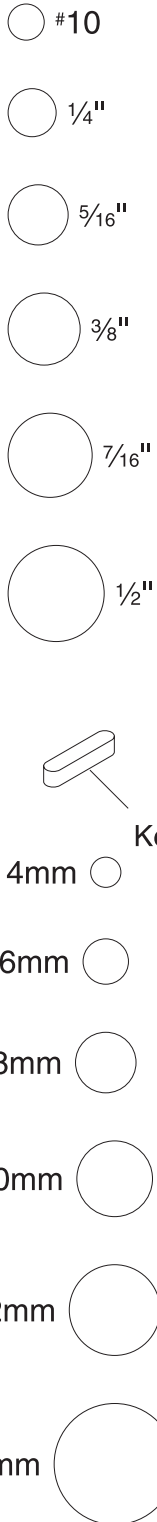
Figure 8. Cabinet inventory.



Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS.

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE




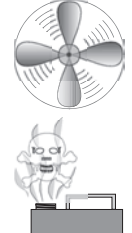
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser, such as shown in **Figure 10**. For thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>⚠ WARNING Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.</p>
---	--

	<p>⚠ CAUTION Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.</p>
---	---

T23692—Orange Power Cleaner & Degreaser
A great product for removing the waxy shipping grease from your machine during clean up.

<p>Call 1-800-523-4777 To Order</p>	
--	---

Figure 10. T23692 Orange Power Degreaser.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors or workbenches may require additional reinforcement to support the machine and operator or machine and workpiece.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 11** for the minimum working clearances.

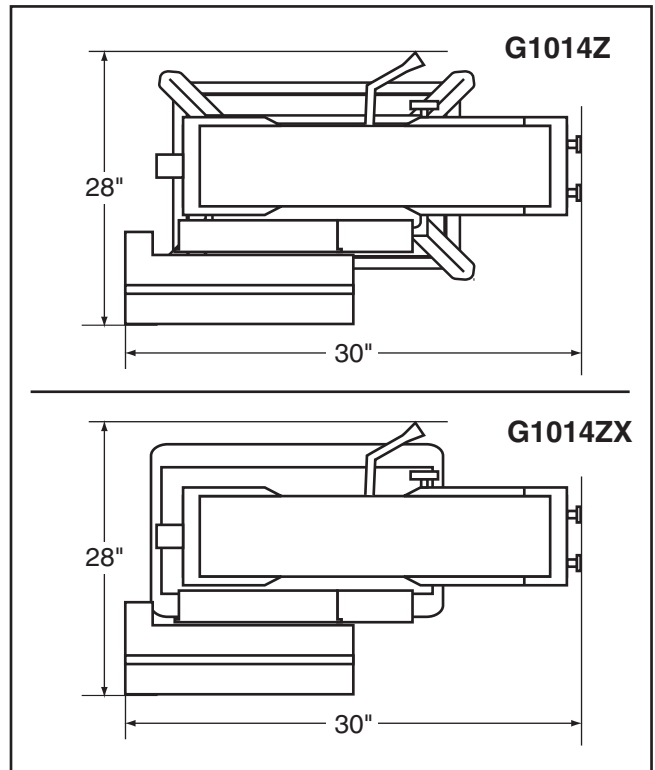
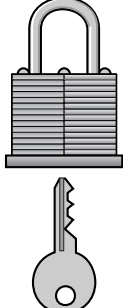


Figure 11. Minimum working clearances.

	<p>⚠ CAUTION Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
--	---



Mounting to Shop Floor

Although not required, we recommend that you mount your new Model G1014Z sander to the floor. The Model G1014ZX sander cabinet cannot be mounted to the floor because the mounting holes cannot be accessed through the cabinet. However, you can use machine mounts on the G1014ZX cabinet.

Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. Whichever option you choose, it is necessary to level your machine with a precision level.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 11**) and anchor studs are two popular methods for anchoring an object to a concrete floor.

We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

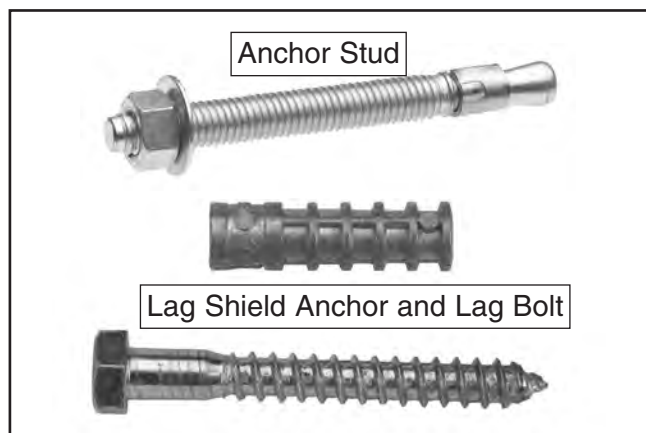


Figure 11. Typical fasteners for mounting to concrete floors.

To mount the Model G1014Z stand to the floor:

1. Follow the instructions for assembling the stand (refer to **G1014Z Stand Assembly on Page 19**).
2. Place the stand on the floor where you plan to mount it.
3. Use a pencil or pen to transfer the stand mounting hole locations onto the floor.
4. Drill holes in the floor and install the stand with the appropriate mounting hardware.
5. Using a precision level, level the stand front-to-back and side-to-side. If necessary, place shims between the floor and the stand to level it.

Mobile Base

You can mount the Model G1014Z to the Model G7314 (shown below) or the G1014ZX to the Model G8683 mobile base (see **Accessories, Page 42**).

G7314—Heavy-Duty SHOP FOX® Mobile Base

Make your machine mobile with this popular patented mobile base. The unique outrigger type supports increase stability and lower machine height. This heavy duty mobile base is rated for up to a 700 lb. capacity.



Figure 12. G7314 SHOP FOX® Mobile Base.



Mounting to Workbench

You can mount your Model G1014Z/G1014ZX to a workbench through the holes in the base, instead of using the included stand or cabinet.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the sander unit to the workbench.

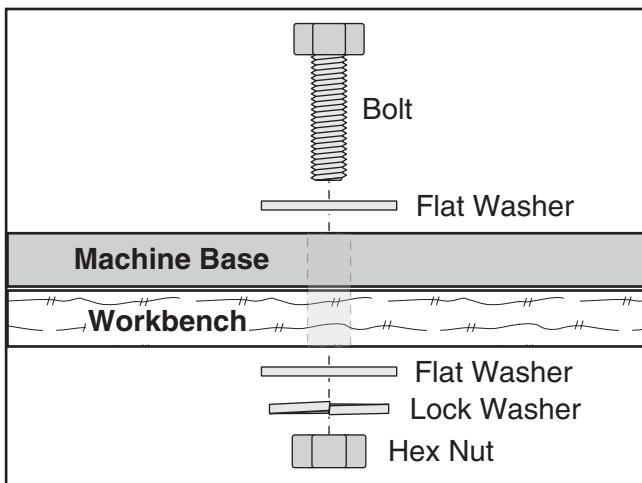


Figure 13. Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw.

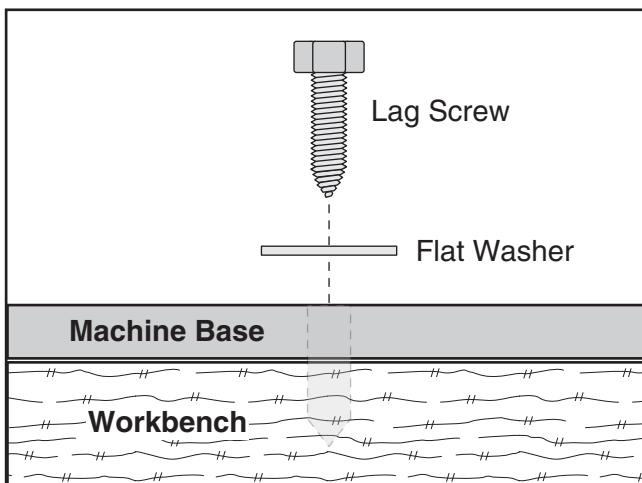


Figure 14. Example of a direct mount setup.

G1014Z Stand Assembly

The Model G1014Z stand can be assembled with the included feet or mounted directly to a concrete floor (refer to **Mounting to Shop Floor** on **Page 18** for further details).

To assemble the G1014Z Stand:

1. Insert a $\frac{5}{16}$ "-18 x 1" hex bolt through the bottom of a rubber foot, then insert the foot into the bottom of a leg and fasten it finger tight with a $\frac{5}{16}$ "-18 hex nut and flat washer, as shown in **Figure 15**.



Figure 15. Foot fastened to bottom of a leg.

2. Repeat **Step 1** to install the remaining feet on the three other legs.



3. Fasten a long upper and long lower brace to the two stand legs with (8) $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " carriage bolts, $\frac{5}{16}$ "-18 hex nuts, and $\frac{5}{16}$ " flat washers, as shown in **Figure 16**. Finger tighten the fasteners for now.

Note: Make sure the lip on the long braces faces up.

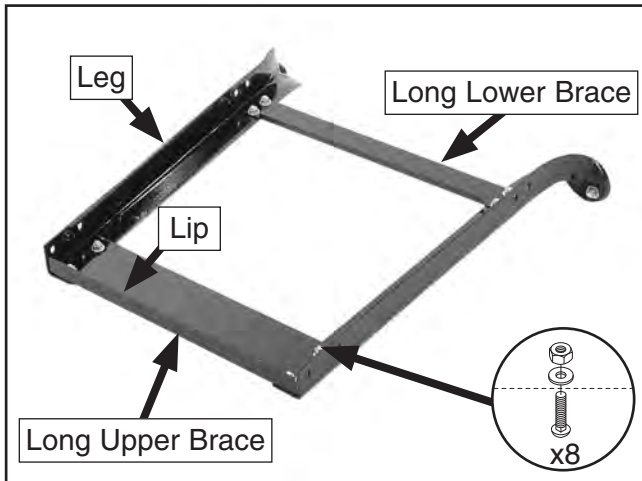


Figure 16. Stand legs fastened to long braces.

4. Repeat **Step 3** to fasten the two remaining long upper and long lower braces to the remaining stand legs.
5. Fasten the two short upper braces and the two short lower braces to one of the leg assemblies with the (8) $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " carriage bolts, $\frac{5}{16}$ "-18 hex nuts, and $\frac{5}{16}$ " flat washers, as shown in **Figure 17**.

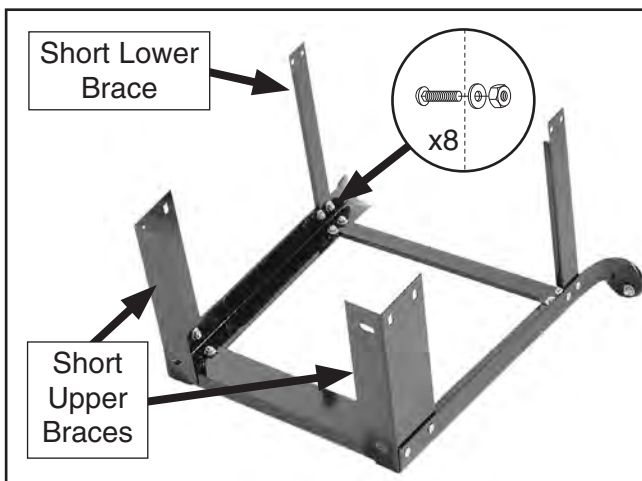


Figure 17. Short upper and lower braces fastened to leg assembly.

Make sure the two short upper braces overlap the long upper braces and that the braces are placed inside the leg assemblies, as shown in **Figure 18**.

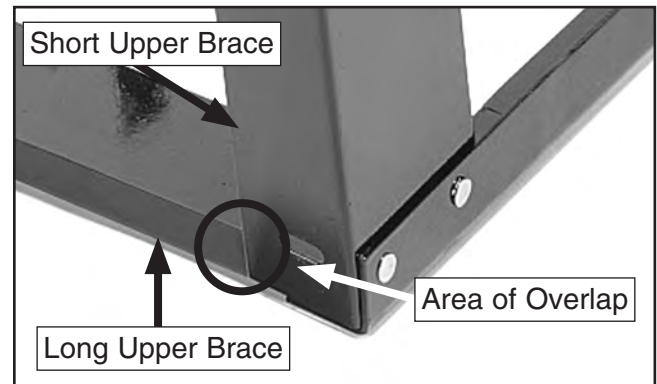


Figure 18. Short brace overlapping long upper brace.

6. Fasten the second leg assembly to the braces on the first leg assembly with the remaining (8) $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " carriage bolts, $\frac{5}{16}$ "-18 hex nuts, and $\frac{5}{16}$ " flat washers, then place the stand upright on its feet, as shown in **Figure 19**.



Figure 19. Stand assembled.

7. Final tighten all the fasteners on the stand.
8. Tighten the lock nuts on the feet.



9. (Optional) Place a level on top of the stand (**Figure 20**) and adjust the stand if needed by shimming the feet so it is level from front-to-back and side-to-side.



Figure 20. Leveling stand.

G1014ZX Cabinet Assembly

To assemble the G1014ZX cabinet:

1. Place the stand flat on its side, but do not lay it down on the switch or door handle.
2. Insert a $\frac{5}{16}$ "-18 x 1" hex bolt through the bottom of each of the four rubber feet, then insert the hex bolt on each foot into the mounting holes on the bottom of the cabinet.
3. Fasten each foot with a $\frac{5}{16}$ "-18 hex nut and $\frac{5}{16}$ " flat washer (see **Figure 21**).



Figure 21. Feet installed onto bottom of cabinet.

Model G1014Z/G1014ZX (Mfg. 11/07+)

4. Place the stand upright on its feet, then place the shelf in the cabinet.
5. (Optional) Place a level on top of the cabinet (see **Figure 22**) and adjust it level from front-to-back and side-to-side by shimming it.



Figure 22. Leveling cabinet.

Sanding Unit Assembly

To assemble the sanding unit:

1. With the help of an assistant, lift the headstock onto the stand (G1014Z) or the cabinet (G1014ZX), and align the mounting holes in the sander unit and the stand or cabinet.

Note: To access the top mounting holes inside the G1014ZX cabinet stand, open the front door.

Tip: Insert the end of the included 4mm hex wrench through the mounting holes in the sanding unit and the stand or cabinet, then jiggle the wrench back and forth to align the mounting holes.



- Secure the sanding unit to the stand or cabinet with the (4) $\frac{5}{16}$ "-18 hex bolts and $\frac{5}{16}$ " flat washers, as shown in **Figures 23 & 24**.

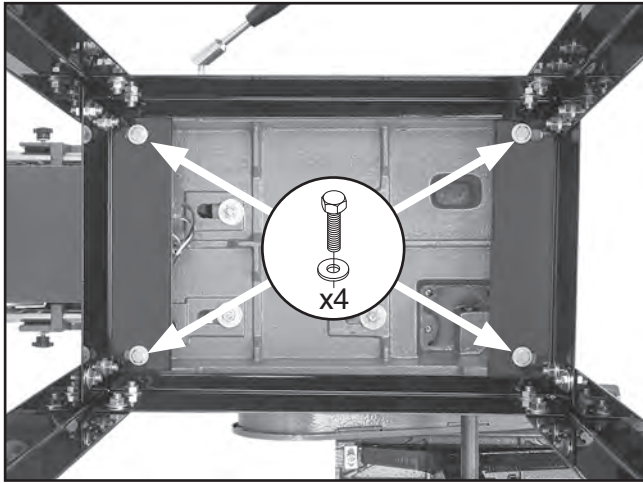


Figure 23. G1014Z sander fastened to stand (view from underneath stand).

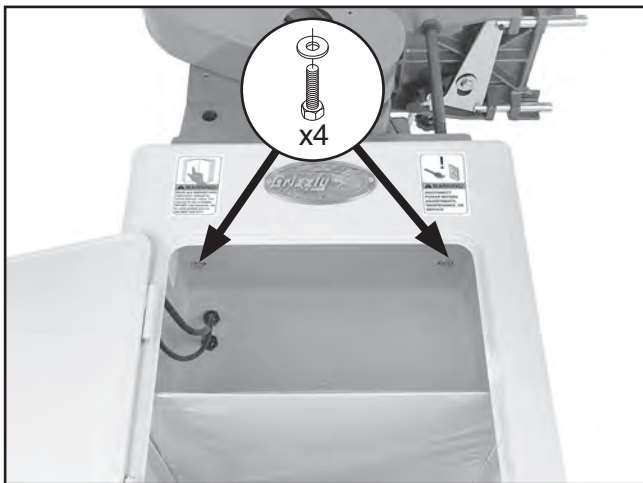


Figure 24. G1014ZX sander fastened to cabinet (two of four hex bolts shown).

- Slide the flat ends of the idler roller into the slots on the roller adjustment bars (see **Figure 25**).

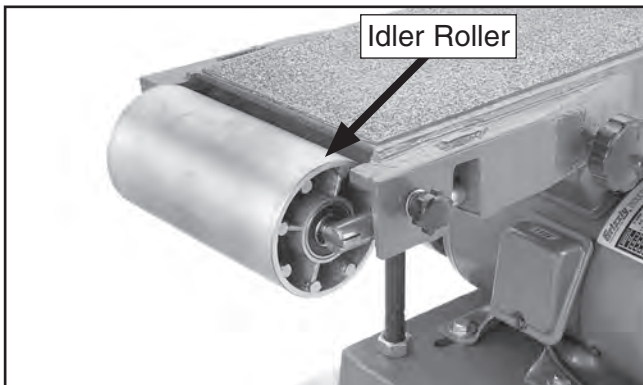


Figure 25. Idler roller installed.

- Use the 4mm hex wrench to back the shaft set screws on the cast iron plate out of the shaft hole and keyway (**Figure 26**).

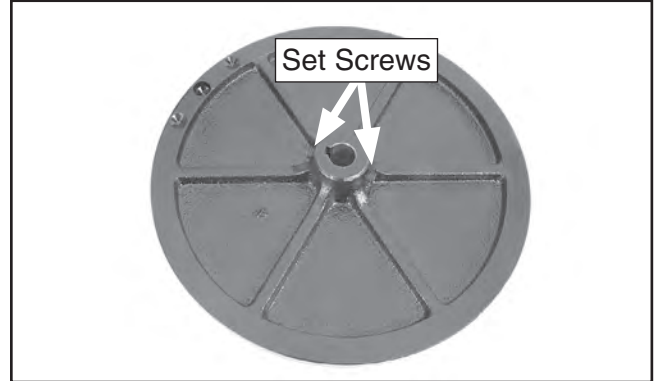


Figure 26. Set screw locations on sanding disc plate.

- Align the keyway on the plate with the drive shaft key, then slide the plate onto the shaft, as shown in **Figure 27**.



Figure 27. Installing plate onto drive shaft.

- Adjust the cast iron plate so it protrudes slightly ($\frac{1}{16}$ "- $\frac{1}{8}$ ") beyond the curved lip of the metal cover on both sides, as illustrated in **Figure 28**, to avoid the possibility of workpieces hitting the cover during sanding operations.

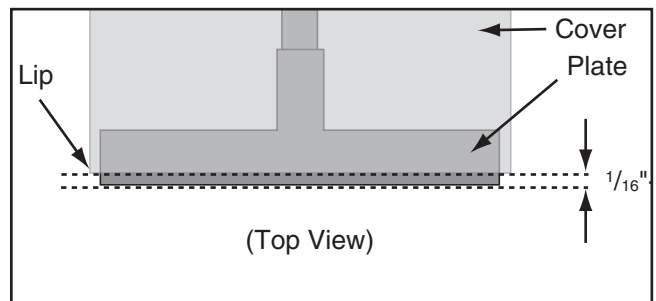


Figure 28. Gap between plate and cover.



7. While looking through the access hole on the side of the cover, rotate the plate and tighten each of the set screws to secure the plate to the drive shaft (see **Figure 29**).

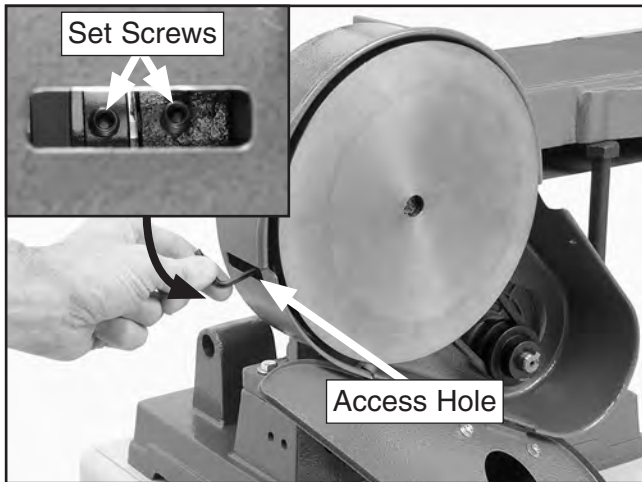


Figure 29. Securing plate to drive shaft.

8. Peel off the backing on the 9" PSA (pressure sensitive adhesive) sanding disc, make sure the cast iron plate is clean, and install the sanding disc onto the plate, as shown in **Figure 30**. Make sure the sanding disc adheres completely flat against the plate.



Figure 30. Installing sanding disc onto cast iron plate.

9. Install the 2½" black plastic dust port onto the pulley cover with the (4) #10-24 Phillips head screws, #10-24 hex nuts and #10 flat washers, as shown in **Figure 31**.

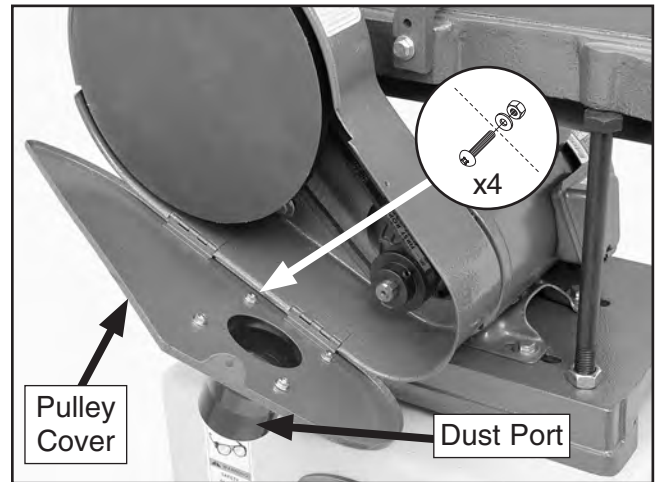


Figure 31. 2½" dust port installed.

10. Secure the pulley cover with the thumb knob.
11. Loosen the two set screws on the back of the base, slide the table support rod into the shaft, making sure the flat of the shaft faces the set screws, then tighten the set screws, as shown in **Figure 32**. The rod should protrude about 6¼" from the side of the base.

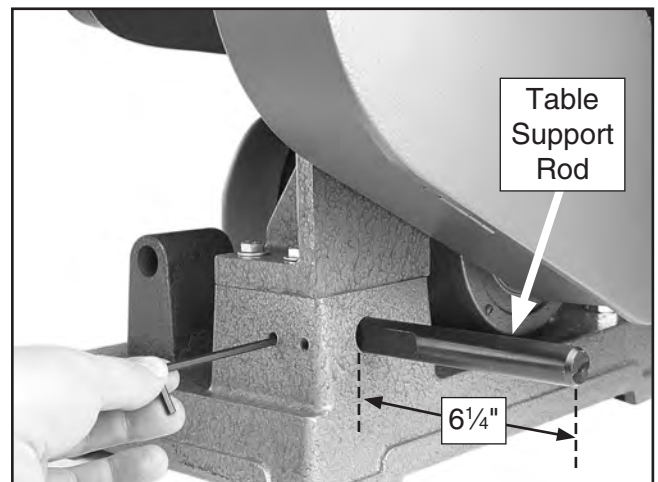


Figure 32. Installing table support rod.



- Loosen the two set screws on the work table arm so their ends are flush with the inside of the opening, as shown in **Figure 33**.

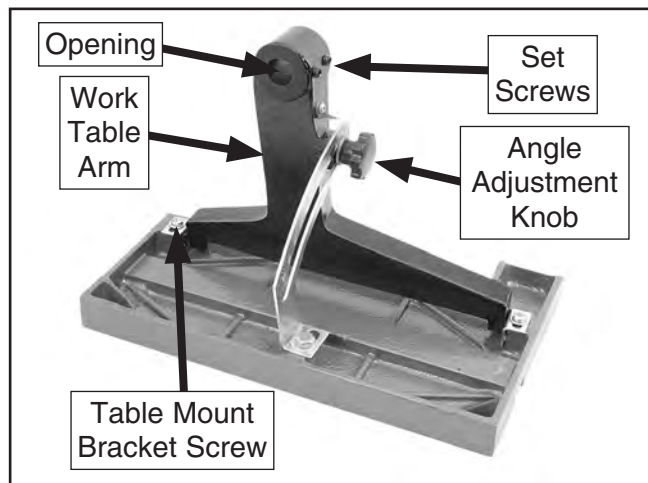


Figure 33. Location of set screws on work table arm.

- Loosen the angle adjustment knob on the work table (**Figure 33**), tilt the table to the 0° mark, then tighten the knob.
- Slide the work table arm onto the table support rod, making sure that the set screws on the table arm face the flat part of the rod, as shown in **Figure 34**.



Figure 34. Installing work table onto table support rod.

- Using a ruler (see **Figure 34**) adjust the edge of the work table approximately $\frac{1}{16}$ " away from the sanding disc on both sides (see **Figure 35**), then tighten the set screws on the work table arm.



Figure 35. Correct distance between disc and work table.

—If the gap between the work table and the sanding disc is not the same on both sides, loosen one of the table mount bracket screws (see **Figure 33**), adjust the table as needed to even the gap, then tighten the screw.

⚠ CAUTION

To reduce the risk of your fingers getting stuck between the work table and sanding disc, set the table approximately $\frac{1}{16}$ " away from the sanding disc.

- Square the table to the sanding disc (refer to instructions on **Page 49** for more details).
- Adjust the miter gauge slot parallel with the sanding disc (refer to instructions on **Page 50** for more details), then insert the miter gauge.



18. Install the 2" dust port onto the back of the sanding belt frame with the pre-installed $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " hex bolts and flat washers, as shown in **Figure 36**.

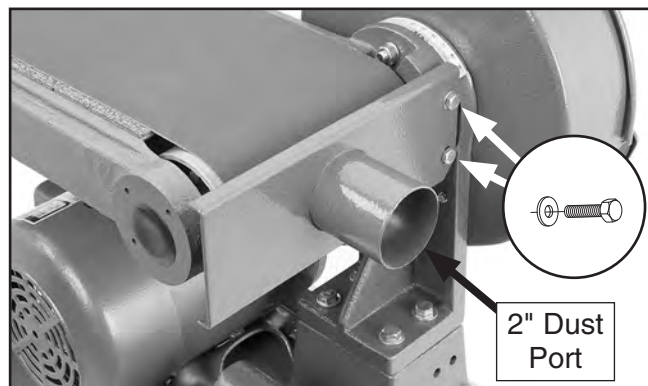


Figure 36. 2" dust port installed.

19. Assemble the quick release lever, as shown in **Figure 37**, using the handle, 6" quick release lever stud, short lever arm, and $\frac{3}{8}$ "-16 hex nuts, thread the assembly into the rocker arm, then tighten the hex nuts.

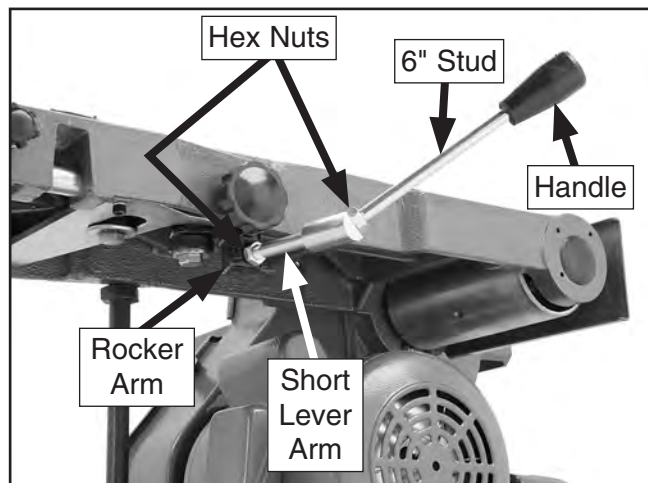


Figure 37. Quick release lever installed.

20. Move the quick release lever toward the motor, slide the sanding belt over the lever and onto the idler roller and drive rollers, then center the belt on the rollers (see **Figure 38**).

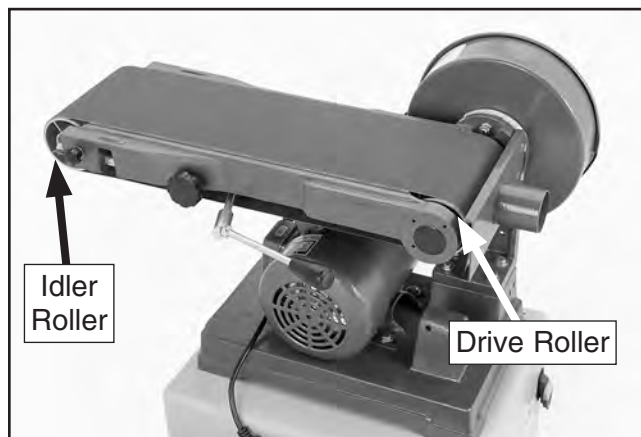


Figure 38. Belt installed onto idler and drive rollers.

21. Push the lever toward the motor to tension the sanding belt.
22. Loosen the thumb knobs behind the idler roller, and install the idler roller assembly (**Figure 39**).

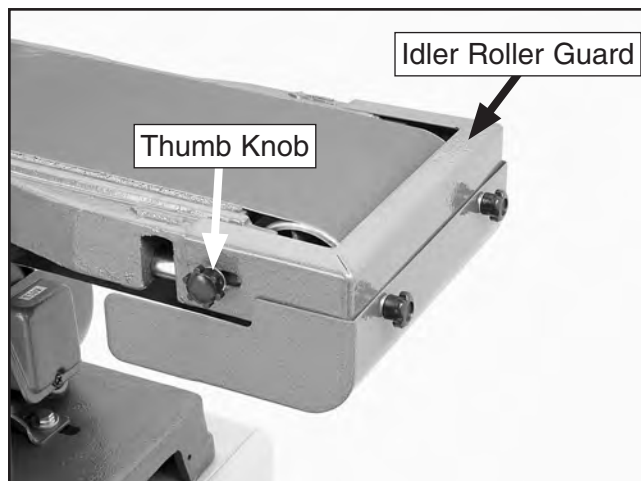


Figure 39. Idler roller guard installed.



23. Adjust the inside edge of the idler roller guard $\frac{1}{4}$ -" $\frac{1}{2}$ " away from the sanding belt (see **Figure 40**).

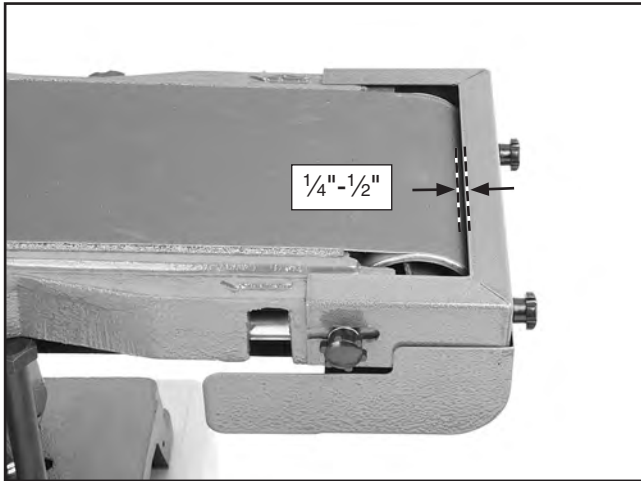


Figure 40. Correct distance between belt and idler guard. Measuring distance (inset).

24. Rotate the sanding belt just enough to verify that the belt does not catch on or rub against the ends of the thumb screws on the sleeve guard.
25. Tighten the thumb knobs located behind the idler roller to secure the guard.
26. **G1014ZX Only:** Connect the motor cord to the power cord on the cabinet (see **Figure 41**). **DO NOT** connect the sander to the power until indicated in the **Test Run** section on **Page 29**.

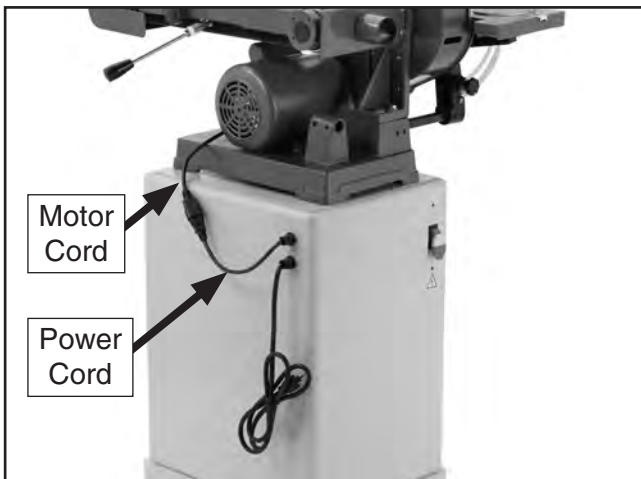


Figure 41. Motor cord connected to power cord.

27. At this point, decide if you want to set up the sanding belt horizontally as in **Step 28**, or follow the instructions on **Page 36** to set up the sanding belt vertically.

28. Loosen the pre-installed $\frac{5}{16}$ "-18 x 1" hex bolt and flat washer on the side of the sanding belt frame, slide the backstop groove onto the bolt, then finger tighten the bolt.
29. Place a square flat against the sanding belt and back stop (see **Figure 42**) adjust the backstop flush with the square on both sides of the belt and $\frac{1}{8}$ " above the belt (see **Figure 43**), then tighten the hex bolt.

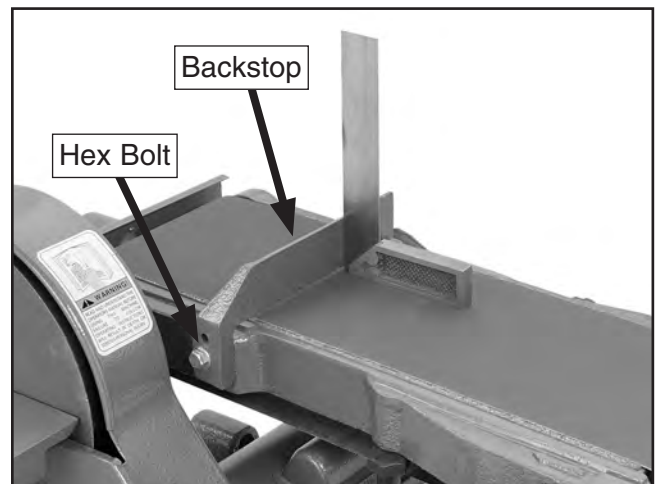


Figure 42. Adjusting backstop square with belt.

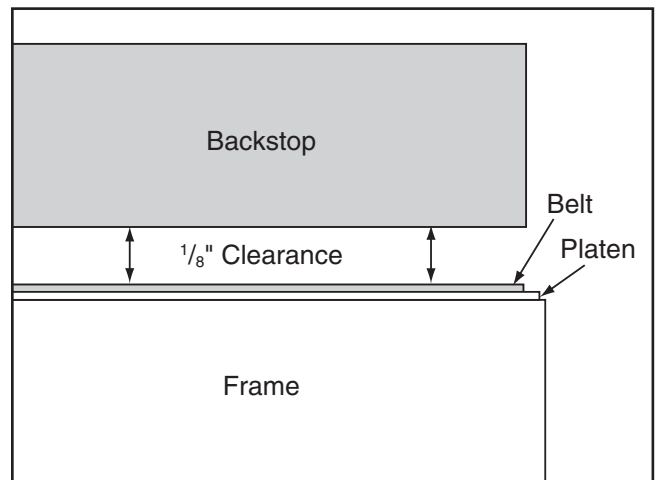


Figure 43. Correct clearance between backstop and belt.



Calibrating Miter Gauge

The miter gauge needs to be calibrated to the sanding disc when it is first mounted in the miter slot.

To calibrate the miter gauge:

1. Place one edge of a machinist's square against the face of the miter gauge and the other against the sanding disc (see **Figure 44**) or sanding belt.

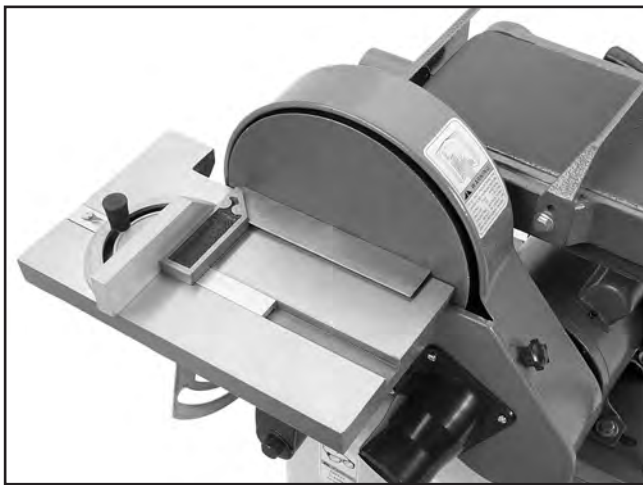


Figure 44. Calibrating miter gauge with square.

2. Loosen the lock knob on the miter gauge and adjust it flush with the edge of the square.
3. Tighten the lock knob and verify the setting.

Note: Sometimes the tightening procedure can affect the adjustment.

4. Loosen the screw that secures the angle pointer and adjust the pointer to the 0° mark on the scale.
5. Retighten the screw that secures the angle pointer.
6. Repeat **Steps 1–5** in a similar manner to calibrate the miter gauge to the belt if you set up the sander for vertical sanding.

Pre-Tracking Belt

You must perform the following procedure before the test run to ensure that the belt does not come off or get jammed against the sanding belt frame.

To pre-track the belt:

1. DISCONNECT SANDER FROM POWER!
2. Loosen the lock nut on the tracking control knob (see **Figure 53** on **Page 31**), then move the quick release tension lever to the tensioned position.

⚠ CAUTION

Fingers or other body parts can be quickly injured if they touch moving sanding surfaces. To reduce the risk of injury, wear gloves during the next step.

3. Standing in front of the sander, push the sanding belt multiple times along the platen, so that it moves in the direction of operation (clockwise on the rollers), then watch how the belt tracks on the rollers.
4. Adjust the tracking with the tracking control knob and continue to rotate the belt by hand until the sanding belt is centered on the main roller, as shown in **Figure 45**.

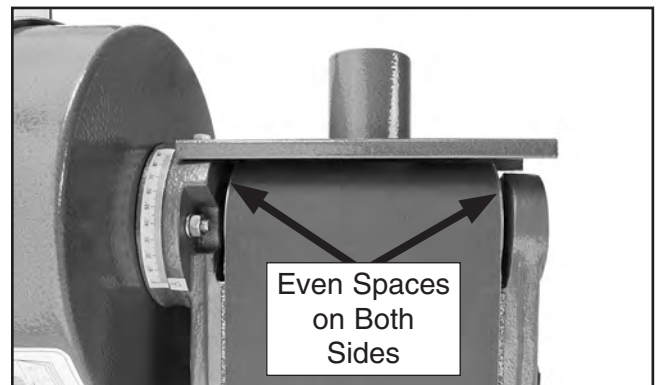


Figure 45. Example of sanding belt centered on main roller.

5. Tighten the tracking control knob lock nut.



Dust Collection

CAUTION

DO NOT operate the Model G1014Z/G1014ZX without an adequate dust collection system. This sander creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at 2" Dust Port: 100
Recommended CFM at 2½" Dust Port: 150

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

The Model G1014Z/G1014ZX features a 2" dust port and a 2½" dust port that can be connected to a dust collector or a dust collection system, using the components shown in **Figure 46**.

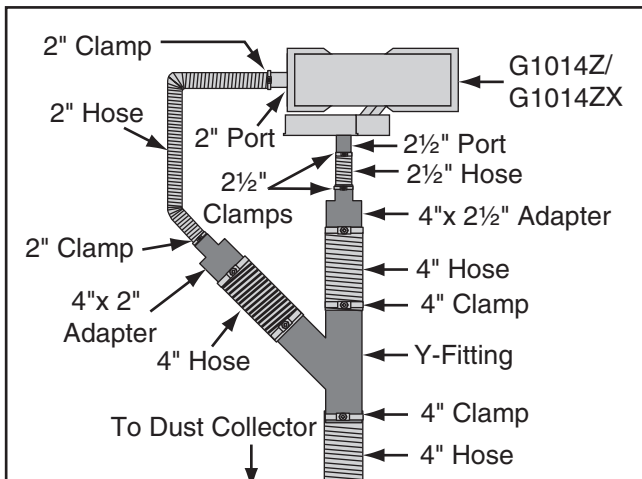


Figure 46. Sander hooked up to 4" hose.

Figure 48 shows a 2" dust hose connected to the dust collection port with a hose clamp.

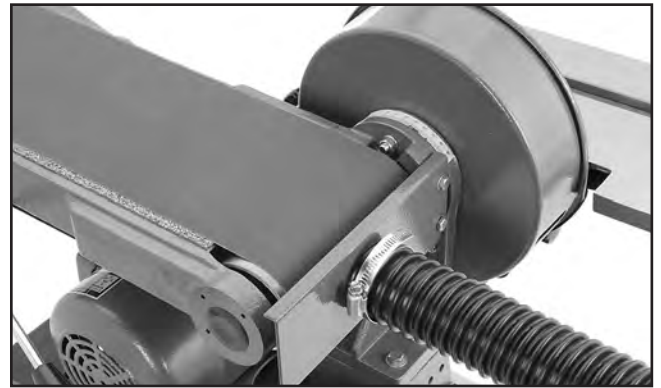


Figure 47. Hose attached to 2" dust port.

Note: A tight fit is necessary for proper performance.

Figure 47 shows a 2½" dust hose attached to the dust port with a hose clamp. After installing the dust hoses on the two ports, tug the hoses to make sure they do not come off.

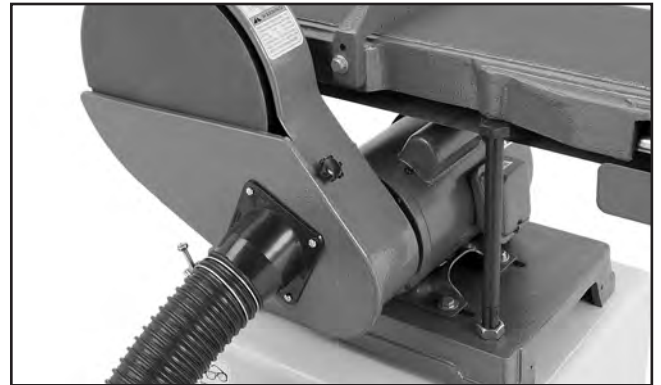


Figure 48. Hose attached to 2½" dust port.

You can also attach a wet/dry vacuum with a 2¼" outside diameter hose to the sander. The hose will slide into the 2½" dust port or fit over the 2" dust port.



Test Run

Test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following:
1) The motor powers up and runs correctly, and
2) the safety disabling mechanism on the switch works correctly.

You must perform the pre-tracking procedure on **Page 27** before starting the sander to ensure that the belt does not come off of the rollers or jam against the sander during startup.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 45**. If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is set up properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Make sure the belt is properly pre-tracked (refer to **Pre-Tracking Belt** on **Page 27**).
4. Tie back loose clothing and long hair to protect yourself from getting caught in the moving sanding belt when you start the sander.
5. Connect the machine to the power source.
6. Verify that the machine is operating correctly by turning it **ON**. Be ready to turn it **OFF** if it tracks over the sanding belt frame edge.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.



⚠ CAUTION

Moving sanding belts are dangerously abrasive. Use extreme caution when working near sanding surfaces.

7. Loosen the lock nut on the tracking control knob, and carefully adjust the tracking in small increments toward the front or back of the sander frame until the sanding belt remains centered on the main roller (see **Figure 45, Page 27**).
8. When the tracking is correct, allow the sander to run for approximately one minute to verify that the tracking stays in the correct position.
9. Repeat **Steps 7–8** if the tracking does not stay correct, otherwise proceed to **Step 10**.
10. When the sanding belt is tracking correctly, tighten the lock nut on the tracking control knob.
11. Turn the machine **OFF**, and remove the switch disabling key, as shown in **Figure 49**.

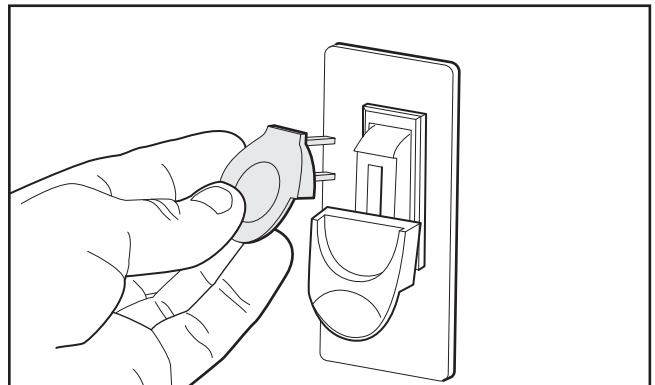


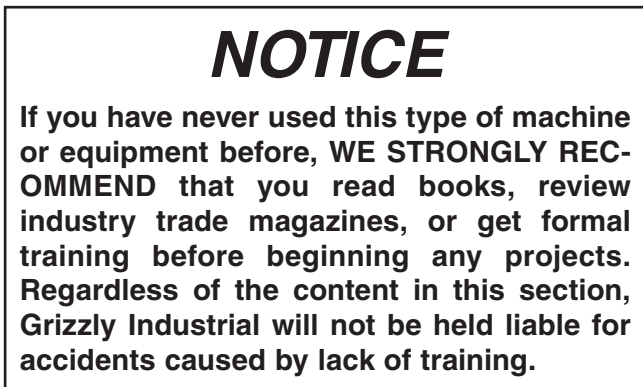
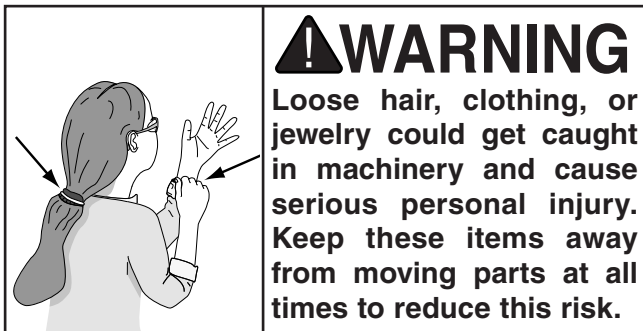
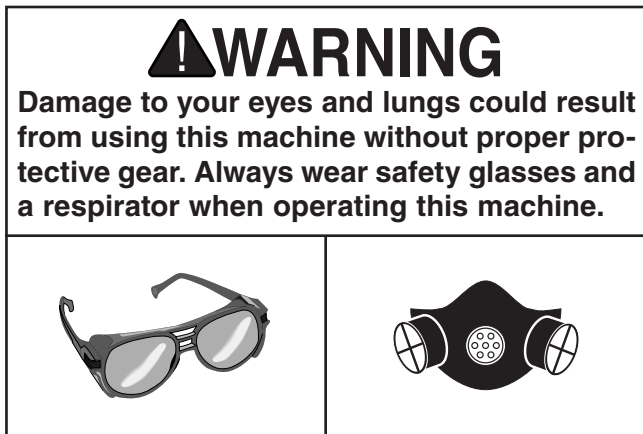
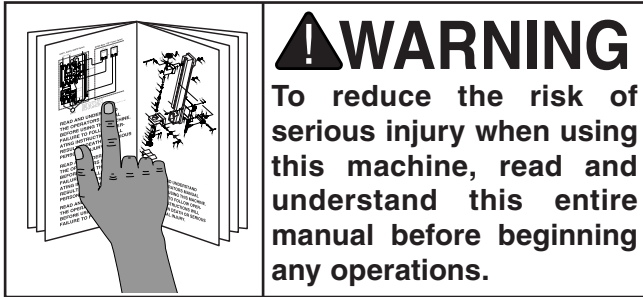
Figure 49. Removing switch key from paddle switch.

12. Try to turn the start the sander with the paddle switch.

—If the sander does not start, the switch disabling feature is working as designed.

—If the sander starts, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

SECTION 4: OPERATIONS



Basic Controls

Refer to **Figures 50–54** and the following descriptions to become familiar with the basic controls of this machine.

Paddle Switch: Turns the motor **ON** when flipped up; turns motor **OFF** when pressed down (**Figure 51**).

Switch Disabling Key: Disables switch when the yellow key is removed.

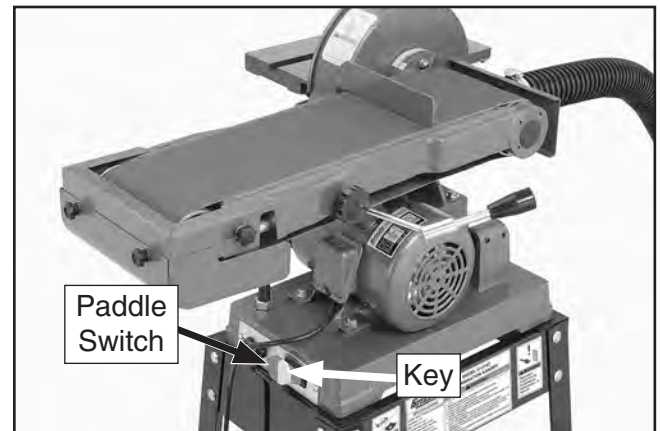


Figure 50. Paddle switch location on G1014ZX.

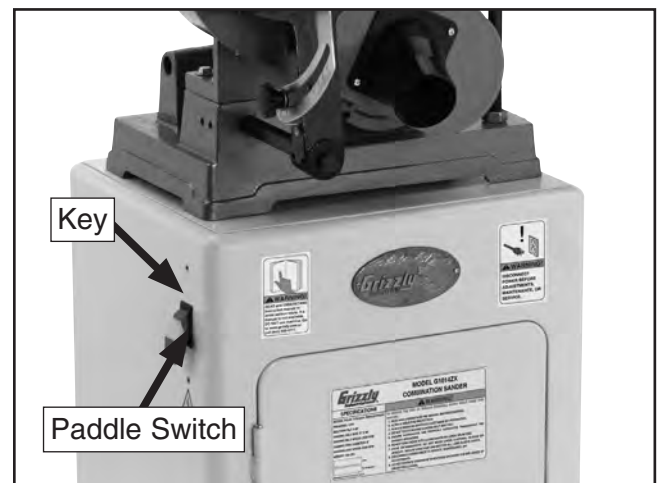


Figure 51. Paddle switch location on G1014Z.



Table Tilt: Use to tilt the table relative to the sanding disc or the sanding belt. To tilt the table, loosen the table tilt lock knob (**Figure 52**), tilt the work table to the desired angle, then retighten the lock knob.

The work table should be set approximately $\frac{1}{16}$ " away from the sanding disc or sanding belt to prevent fingers or workpieces from getting caught. To adjust the work table relative to the sanding disc, refer to **Step 16** in **Sanding Unit Assembly** on **Page 24**. To adjust the work table relative to the belt, refer to **Step 9** in "Setting up Sander for Vertical Sanding" on **Page 37**.

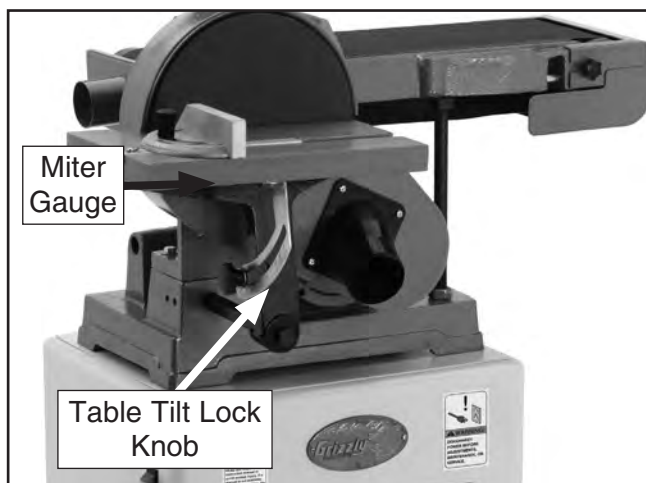


Figure 52. Table tilt controls.

Miter Gauge: Use to move workpieces into the sanding disc (horizontal sanding) or belt (vertical sanding) at a specific angle. To use the miter gauge (**Figure 52**), slide it into the miter slot, loosen the lock knob, set the angle, then tighten the knob.

Belt Tracking and Tension: The quick release tension lever (see **Figure 53**) tensions the belt. To tension the sanding belt, move the quick release tension lever toward the motor.

The tracking control knob keeps the belt in the center of the idler and drive rollers. To adjust the belt tracking, loosen the lock nut on the tracking control knob. Turn the motor **ON**, adjust the tracking in small increments with the knob, then tighten the lock nut to secure the knob. (Refer to **Tracking Belt** instructions on **Page 40** for more details.)

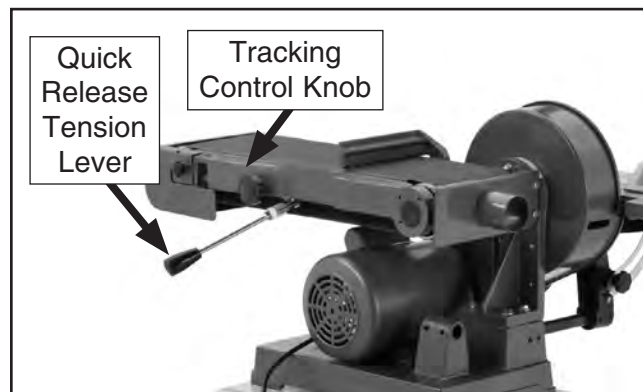


Figure 53. Belt tracking and tension controls.

Vertical Tilt and Work Table Position:

The sanding belt frame can be tilted to the vertical position (see **Figure 54**) and the work table can be moved behind the motor to support workpieces during vertical sanding. (See **Vertical Sanding** on **Page 36** for more detail.)



Figure 54. Model G1014ZX set up for vertical sanding.

Operation Overview

This combination sander removes surface material from the edges, ends, and faces of wood stock using an abrasive belt and disc. A graphite coated platen on the sanding belt frame provides a flat support surface for the sanding belt and workpiece.

The abrasive belt revolves around a pair of metal rollers, one of which is driven by the motor. The adhesive-backed abrasive disc is attached to a cast iron disc, which revolves in a counterclockwise direction.

During a typical operation, the sander is turned **ON**, and while holding the workpiece with both hands, the operator gradually eases the workpiece into the belt or the left side of the sanding disc.



Sanding Tips

- Replace the sandpaper with a higher grit to achieve a finer finish.
- Extend the life of the sandpaper by regularly using PRO-STICK® abrasive belt cleaners (see **Accessories** on **Page 41**).
- When sanding workpieces with a bow or crown, place the high point up on the table (prevents the workpiece from rocking) and take very light passes.

Choosing Sandpaper

The Model G1014Z/G1014ZX uses a 6" x 48" sanding belt and a 9" sanding disc.

There are many types of sanding belts and discs to choose from. We recommend aluminum oxide for general workshop environments. Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

Grit	Class
36	Extra Coarse
60	Coarse
80–100	Medium
120–180	Fine

The general rule of thumb is to sand a workpiece with progressively higher grit numbers, with no one grit increase of more than 50 grits at a time. Avoid skipping grits; the larger the grit increase, the harder it will be to remove the scratches from the previous grit.

Ultimately, the type of wood you use and your stage of finish will determine the best grit types to install on your sander.

Stock Inspection and Requirements

Some workpieces are not safe or may require modification before they are safe to sand. **Before sanding, inspect all workpieces for the following:**

- **Material Type:** This machine is intended for **ONLY** sanding natural and man-made wood products. This machine is **NOT** designed to sand metal, glass, stone, tile, drywall or cementitious backerboard.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear the sanding belt. Always visually inspect your workpiece for these items. If they can't be removed, **DO NOT** sand the workpiece.
- **Excessive glue or finish:** Sanding workpieces with excess glue or finish will load up the abrasive, reducing its usefulness and lifespan.
- **Workpiece Dimensions:** **DO NOT** sand boards less than 9" long, 1/8" wide and 1/16" thick to prevent damage to the workpiece to reduce the risk of your hands contacting the abrasive belt (see **Figure 30**).

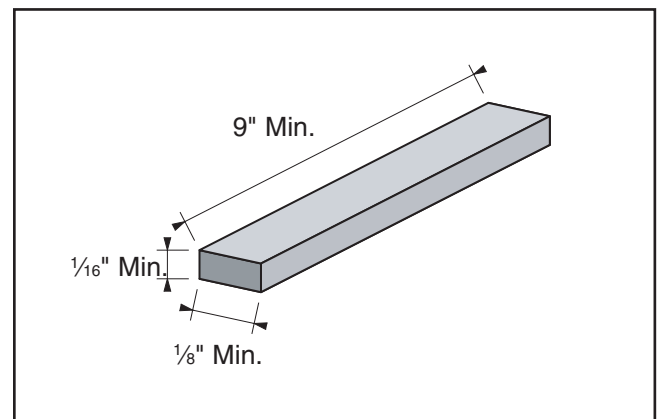


Figure 30. Minimum dimensions for sanding.



Horizontal & Edge Sanding

If the sanding belt frame is in the vertical position, proceed to "Setting Up Sander for Horizontal and Edge Sanding" below to setup the sander for horizontal sanding. If the sander is already in the horizontal position, skip ahead to "Performing Horizontal Sanding and Edge Sanding."

Setting Up Sander for Horizontal Sanding

1. Loosen the set screws that secure the work table support rod to the mounting bracket behind the motor, then remove the work table assembly (see **Figure 55**).



Figure 55. Location for removing work table assembly.

2. Loosen the sanding frame rotation lock nuts (behind the sanding disc cover), rotate the frame to the horizontal position, as shown in **Figure 56**, then tighten the rotation lock nuts.

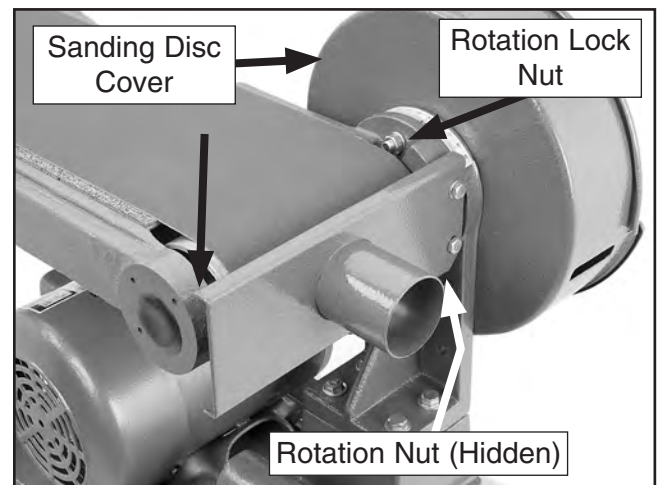


Figure 56. Table tilted to horizontal position.

3. Insert the table support rod into the hole in the base under the sanding disc, and position the work table $\frac{1}{16}$ " away from the sanding disc, as shown in **Figures 34–35** on **Page 24**.
4. Check that the miter gauge slot-sanding disc distance is correct (see instructions on **Page 50** for further detail).
5. Re-install the backstop so it is square with and $\frac{1}{8}$ " above the sanding belt (see **Figure 42** on **Page 26**).

Performing Horizontal or Edge Sanding

1. Make sure the sanding belt is tensioned—if it is not already tight.
2. Make sure the belt tracking is correctly set (see **Tracking Belt** on **Page 40**).
3. Turn the sander **ON**.



4. While holding the back end of the workpiece against the backstop with both hands, and while keeping your fingers away from the belt, slowly feed the workpiece into the belt, as shown in **Figures 57 & 58**.

Note: Apply even pressure and move the workpiece back and forth across the sanding belt.



Figure 57. Sanding workpiece in horizontal position.



Figure 58. Sanding edge of workpiece in horizontal position.

!WARNING

Sanding surfaces can cause serious personal injury if they come in contact with fingers, hands or other body parts. Use extreme care to provide a safe distance between the belt and any part of your body.

Contour Sanding

To perform contour sanding:

1. Make sure the sanding belt is tensioned—if it is not already tight.
2. Make sure the belt tracking is correctly set (see **Tracking Belt** on **Page 40**).
3. Loosen the knobs that secure the idler roller guard and sleeve guard assembly, then remove the guard.
4. Turn the sander **ON**.

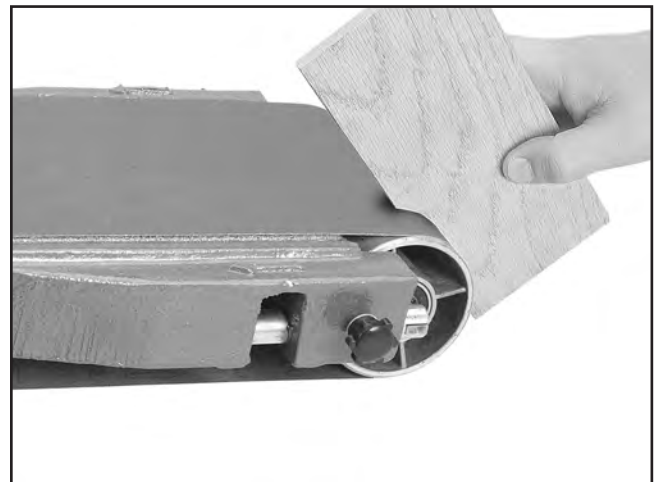


Figure 59. Example of contour sanding.

5. Slowly feed the workpiece into the curved end of the belt and continue moving the workpiece profile along the contour until you achieve your desired shape, as shown in **Figure 59**.

!WARNING

Do not operate this equipment when wearing loose clothing, gloves, neckties, rings, bracelets or other jewelry that might get caught in the moving belt. Serious personal injury may result. You must re-install the idler roller and sleeve guard before performing edge or horizontal sanding operations.

6. Re-install the idler roller and sleeve guard.



Disc Sanding

The sanding disc can be used to smooth the ends of workpieces.

⚠ CAUTION

To reduce the risk of your fingers getting trapped between the work table and sanding disc, make sure the table is approximately $\frac{1}{16}$ " away from the sanding disc.

⚠ CAUTION

Always keep the workpiece on the left side of the wheel that rotates down toward the work table. This will keep the workpiece from flying out of your hands due to kickback.

To use the sanding disc:

1. DISCONNECT SANDER FROM POWER!
2. Adjust the angles of the work table and the miter gauge for your operation.
3. Connect the sander to power, turn it **ON**, and allow it to reach full speed.
4. Place the workpiece on the work table and firmly against the miter gauge.
5. Slowly, and with light pressure, move the workpiece into the left side of the sanding disc. See **Figures 60–63** for examples of disc sanding.



Figure 60. Example of 90° disc sanding.



Figure 61. Example of miter sanding.

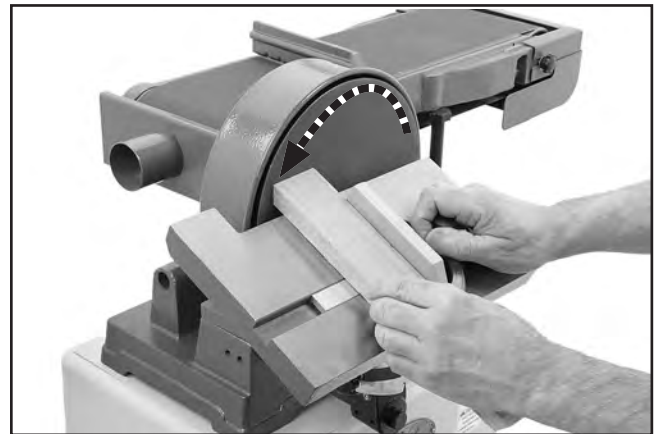


Figure 62. Example of angle sanding.



Figure 63. Example of sanding round workpiece.

Note: To prevent burning the workpiece and overloading the sanding disc, move the workpiece slowly back and forth from the left side of the sanding disc to the center.



Vertical Sanding

If the sanding belt frame is in the horizontal position, proceed to **Setting up Sander for Vertical Sanding**. If the sander is already in the vertical position, skip to **Performing Vertical Sanding** on **Page 38**.

Setting up Sander for Vertical Sanding

1. Make sure the sanding belt is tensioned—if it is not already tight.
2. Make sure the belt tracking is correctly set (see **Tracking Belt** on **Page 40**).
3. **DISCONNECT SANDER FROM POWER!**
4. Remove the backstop and miter gauge from the work table.
5. Loosen the sanding frame rotation lock nuts (behind the sanding disc cover) as shown in **Figures 64 & 65**.

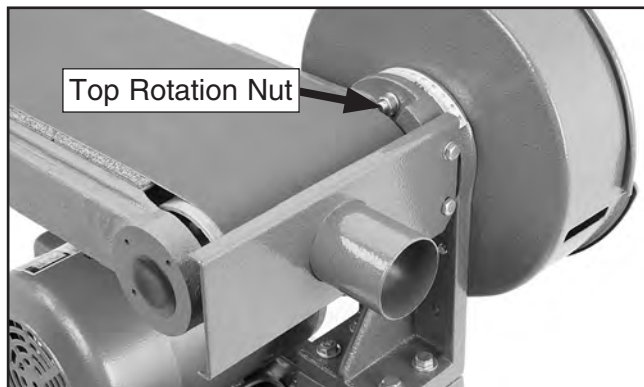


Figure 64. Location of top rotation lock nut.

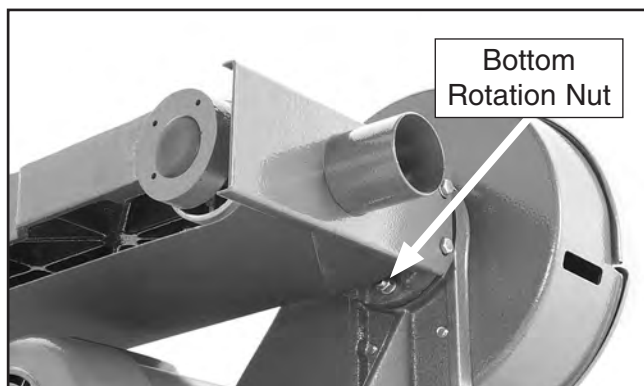


Figure 65. Location of bottom rotation lock nut.

6. Raise the sanding belt frame until it reaches the 90° mark (or the desired angle) on the tilt scale, as shown in **Figure 66**, then tighten the rotation lock nuts.

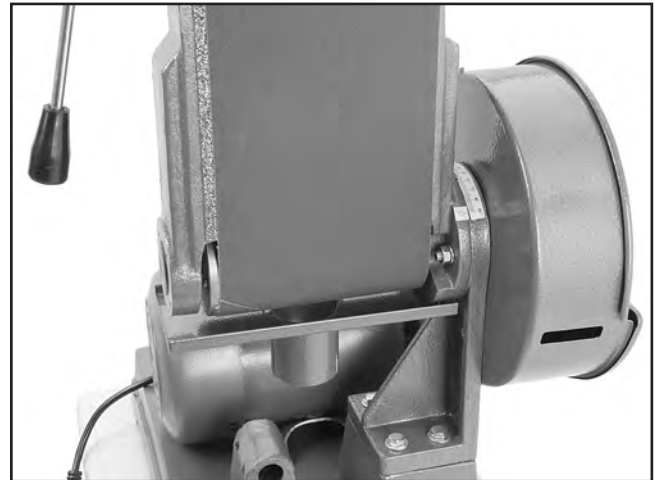


Figure 66. Sanding belt tilted to 90° position.

7. Loosen the set screws that secure the table support rod under the sanding disc, then remove the support rod and work table assembly.
8. Loosen the set screws on the mounting bracket behind the motor, then slide the support rod and work table assembly into the bracket hole, as shown in **Figure 67**.

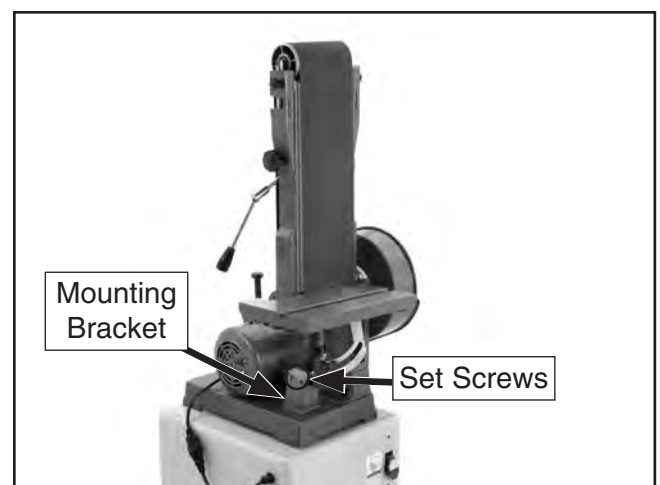


Figure 67. Work table installed for vertical sanding.



- Adjust the front of the work table $\frac{1}{16}$ " away from the sanding belt (see **Figure 68**) across its entire length.

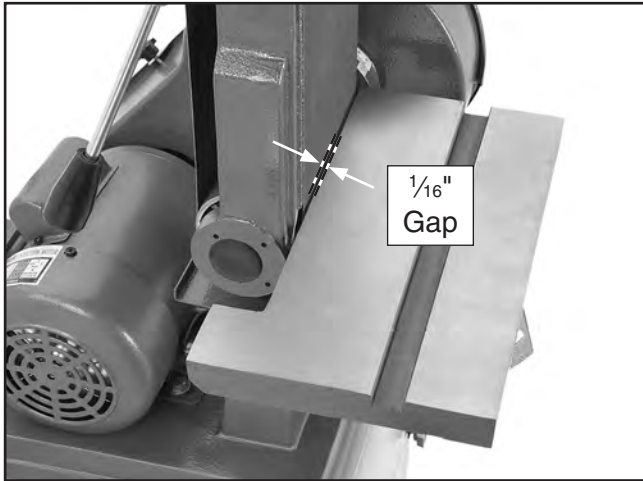


Figure 68. Correct distance between work table and sanding belt.

—If the gap is not $\frac{1}{16}$ " across the entire length of the work table, loosen one or both of the screws under the table (see **Figure 69**), where the arm is attached to the table, and adjust the table until the distance is correct, then tighten the screws.

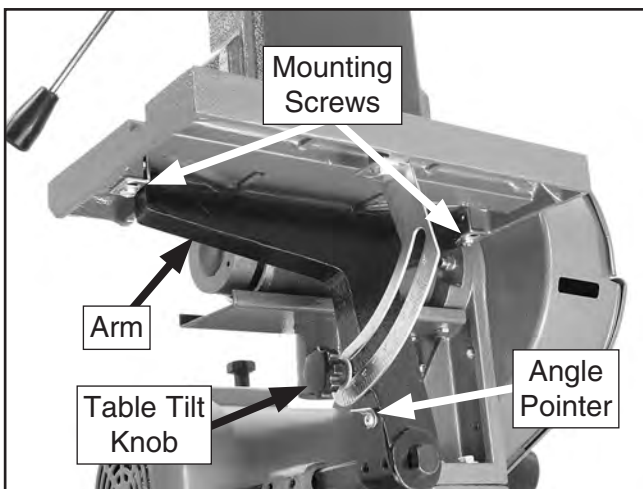


Figure 69. Location of work table arm mounting screws.

Note: To reduce the chance of vibration or rattling sounds, make sure the table support rod does not touch the motor.

- Tighten the mounting bracket set screws to secure the support rod.

- Place a machinist's square on the work table and against the sanding belt, as shown in **Figure 70**, and check for gaps between the square, belt, and table.



Figure 70. Squaring table and sanding belt.

—If there are any gaps, loosen the table tilt knob, adjust the table as needed to remove the gaps, then tighten the knob. Loosen the angle pointer screw, position the pointer over the zero mark on the scale, then tighten the screw.

- Use a fine ruler or combination square to check if the distance from the slot to the belt is the same at both edges of the belt.

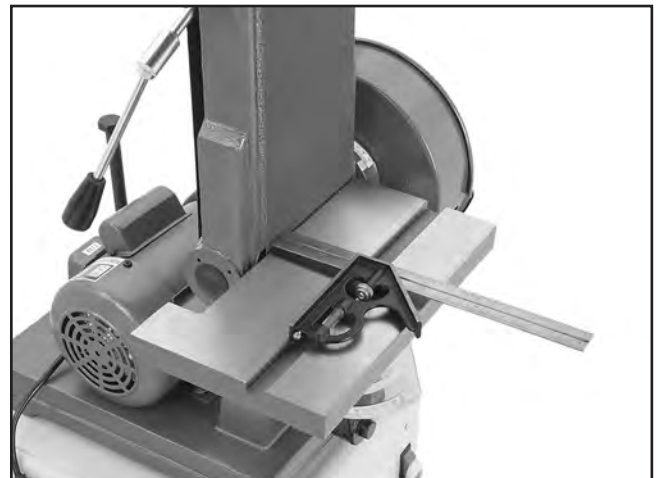


Figure 71. Checking miter slot-belt distance.

—If the distance is the same, no adjustments need to be made.



—If the distance is not the same from side-to-side, loosen the screws that secure the work table arm to the work table. Then adjust the table until the miter slot-belt distance is even side-to-side and the table is approximately $\frac{1}{16}$ " away from the belt across its entire length.

13. Insert the miter gauge into the left side of the miter slot.

Performing Vertical Sanding

1. Adjust the angles of the work table and miter gauge for your operation.
2. Place the workpiece on the table and firmly against the miter gauge.
3. Slowly and with light pressure, move the workpiece into the left side of the sanding belt. See **Figures 72–75** for examples of horizontal belt sanding.



Figure 72. Example of end grain sanding.



Figure 73. Example of vertical miter sanding.

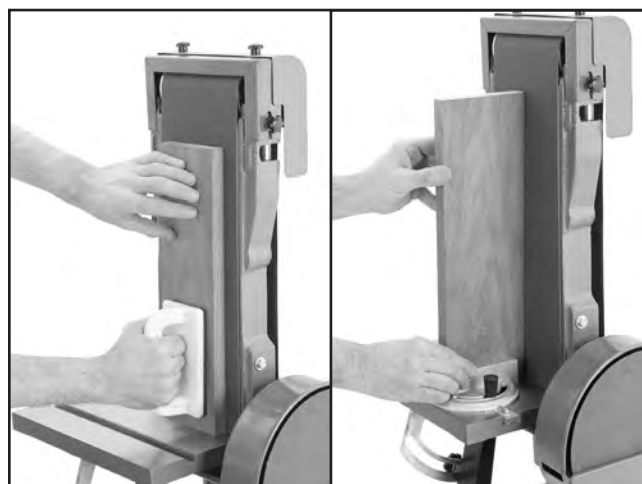


Figure 74. Example of vertical face and edge sanding.



Figure 75. Example of sanding round workpiece in vertical position.



Changing Sanding Belt

Some sanding belts are designed to sand in only one direction and will have a direction indicated on the back of the belt. The Model G1014Z/G1014ZX is designed so that the sanding belt travels clockwise as viewed from the side with the quick release tension lever.

To change the sanding belt:

1. DISCONNECT SANDER FROM POWER!
2. Move the quick release lever away from the motor to release the belt tension.
3. Remove the idler roller guard and back stop.
4. Remove the belt from the rollers and sanding belt frame.
5. Install a new sanding belt onto the idler and drive rollers, making sure the arrows on the bottom of the belt face the front of the sander, as shown in **Figure 76**.

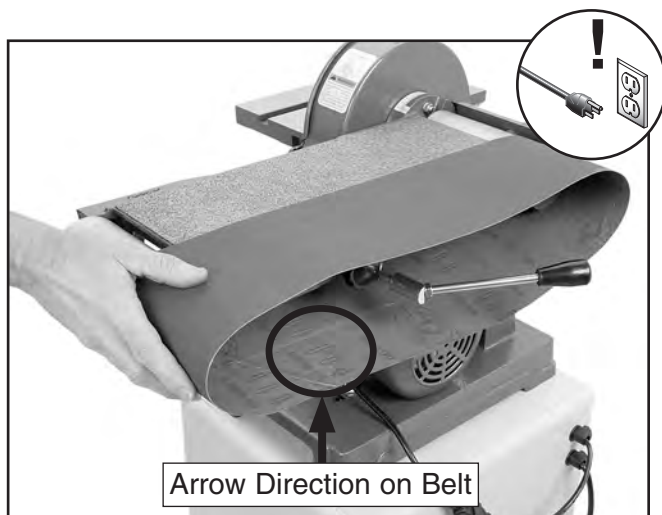


Figure 76. Installing new sanding belt.

6. Position the belt in the center of the roller, then move the quick release tension lever toward the motor to tension the belt (see **Figure 77**).

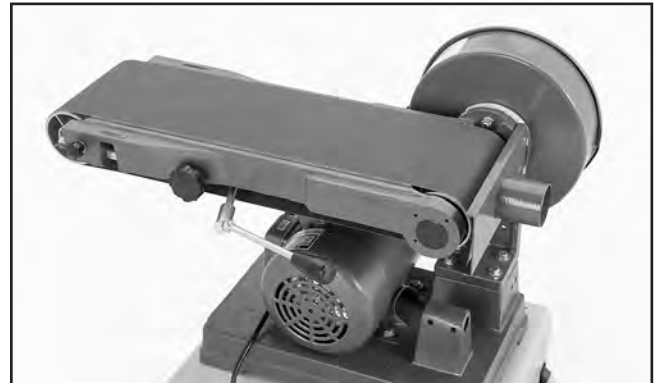


Figure 77. New belt installed.

7. Re-install the back stop.
8. Perform the belt pre-tracking procedure (refer to **Pre-Tracking Belt** on **Page 27**).
9. Perform the belt tracking procedure outlined below.



Tracking Belt

The aim of tracking the belt is to keep it centered on the rollers.

To track the belt:

1. Make sure the belt is properly pre-tracked (refer to **Pre-Tracking Belt** on **Page 27**).
2. Tie back loose clothing and long hair to protect yourself from getting caught in the moving sanding belt when you start the machine.
3. Move the quick release tension lever toward the back of the sander to tension the belt.
4. Loosen the lock nut on the belt tracking knob.
5. Turn the sander **ON**, and using the tracking control knob (**Figure 78**), carefully adjust the tracking in or out until the sanding belt is centered on the main roller (see **Figure 45, Page 27**).

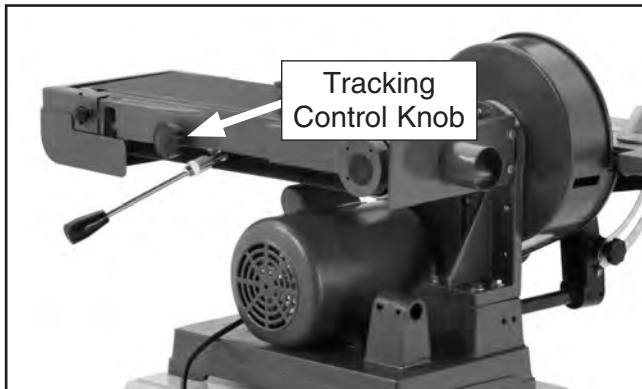


Figure 78. Tracking control knob.

Note: *The tracking control knob is very sensitive; adjust it carefully in small increments. Turning the knob clockwise moves the belt toward the front of the sander.*

6. Tighten the belt tracking knob lock nut.

Changing Sanding Disc

The model G1014Z/G1014ZX accepts 9" diameter paper-backed pressure sensitive adhesive (PSA) discs (refer to **Accessories** on **Page 41**).

To change the sanding disc:

1. DISCONNECT SANDER FROM POWER!
2. Remove the work table and miter gauge.
3. Unscrew the pulley cover thumb knob, open the cover, then remove the existing PSA disc.
4. Remove dried-on adhesive from the cast iron disc with acetone or lacquer thinner and a brush, then let it dry. **CAUTION:** *Follow the manufacturer's safety recommendations when using acetone or lacquer thinner.*
5. Peel off the backing from the new PSA disc, then press it onto the cast iron plate, making sure it contacts the surface evenly.
6. Close the pulley cover, re-install the lock knob, then re-install the work table and miter gauge.



SECTION 5: ACCESSORIES

6" x 48" Aluminum Oxide Sanding Belts

Our aluminum oxide sanding belts are available in grits from 60–220 and packs of 2.

Grit	Model
60 Grit, 2 pack	G1214
80 Grit, 2 pack.....	G4283
100 Grit, 2 pack.....	G1215
120 Grit, 2 pack.....	G4284
150 Grit, 2 pack.....	G1216
180 Grit, 2 pack.....	G4285
220 Grit, 2 pack.....	G4286

9" PSA Aluminum Oxide Sanding Discs

Our aluminum oxide sanding discs are manufactured in ISO 9002 factories to ensure the highest quality and are available in packs of two.

Grit	Model
60 Grit.....	G1217
80 Grit.....	G4244
100 Grit.....	G1218
120 Grit.....	G4245
150 Grit.....	G1219
180 Grit.....	G4246
220 Grit.....	G4247

Pro-Stik® Abrasive Belt Cleaners

G1511—Small: (1½" x 1½" x 8½")

G1512—Large: (2" x 2" x 12")



Figure 79. Pro-Stik® Belt Cleaners.

Call 1-800-523-4777 To Order

T20501—Face Shield Crown Protector 4"

T20502—Face Shield Crown Protector 7"

T20503—Face Shield Window

T20448—Economy Clear Safety Glasses

T20452—"Kirova" Anti-Reflective Glasses

T20456—"Dakura" Clear Safety Glasses

H0736—Shop Fox® Safety Glasses

These glasses meet ANSI Z87.1-2003 specifications. Buy extras for visitors or employees. You can't be too careful with shop safety!



Figure 80. Our most popular eye protection.

T20514—Small Half-Mask Respirator

T20515—Medium Half-Mask Respirator

T20516—Large Half-Mask Respirator

T20511—Pre-Filter P100

T20539—Cartridge Filter 2PK P100

T20541—Cartridge Filter 2PK P100 & O Vapor

Wood and other types of dust can cause severe respiratory damage. If you work around dust everyday, a half-mask respirator can greatly reduce your risk. Compatible with safety glasses!

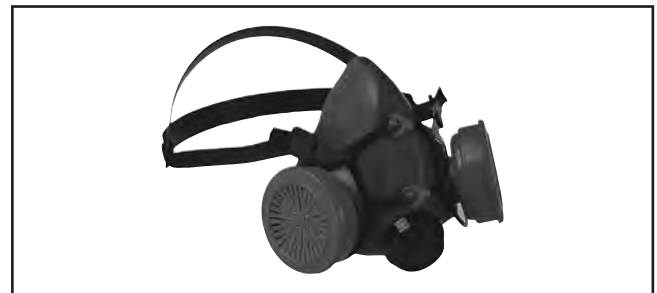


Figure 81. Half-mask respirator with disposable cartridge filters.



G1029Z—2HP Dust Collector

The great combination of price and performance make this one of the most popular dust collectors we sell. Perfect for use as a central dust collector in a small shop or as a "dedicated" dust collector next to an industrial machine. Features 220V single-phase power, 1550 CFM, 2.5 micron filtration, and a 6" main inlet w/included 4" x 2" "Y" fitting.



Figure 82. G1029Z 2HP Dust Collector.

G5955—Heavy Duty Hanging Air Filter

This ceiling mounted air filter system can clean up to 98% of airborne contaminants without affecting existing room temperatures. Features continuous duty, low noise motor, easy clean double filter design and heavy gauge steel cabinet. Moves 510 CFM of air. Measures 30⁵/₁₆" x 24" x 12³/₁₆".

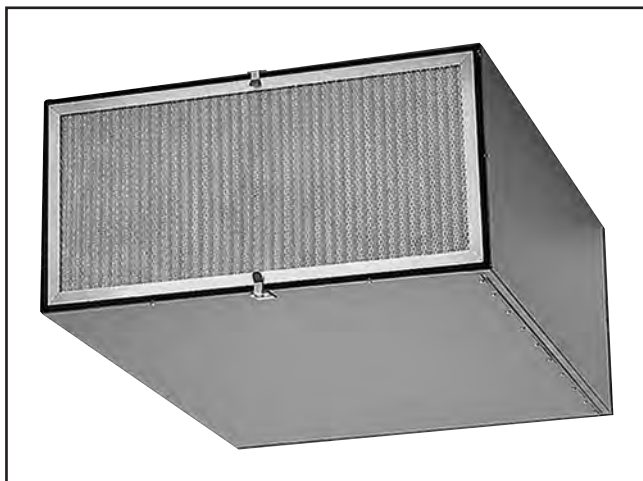


Figure 83. G5955 Air Filter.

G8683—Mini SHOP FOX® Mobile Base

Shop Fox mobile bases are the strongest bases on the market. Adjusts from 10¹/₂" x 14¹/₂" to 17" x 21¹/₂". Has outrigger supports and a stable 4 wheel system. 600 lb. capacity. Weighs 32 lbs.



Figure 84. G8683 SHOP FOX® Mobile Base.

G2405—Safety Push Blocks

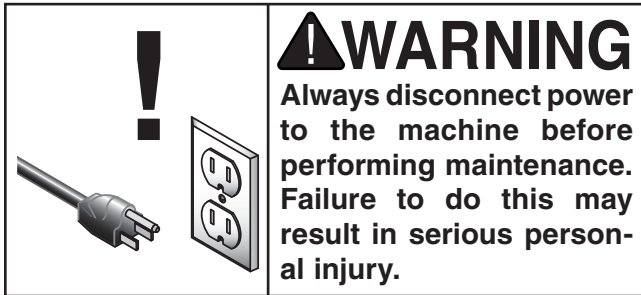
Made of high-impact molded plastic, these safety push blocks have a layer of friction rubber on the bottom that grabs your workpiece as you press down. We strongly recommend these for use with jointers, router tables, shapers and table saws. Measures 3" x 6".



Figure 85. G2405 Safety Push Blocks.



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Damaged or worn sanding belt or disc.
- Check cords, plugs, and switch for damage.
- Wipe the work table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.
- Worn or damaged wires.
- Any other unsafe condition.

After Each Use:

- Clean/vacuum dust buildup on tables and motor.

Monthly Check:

- Check and lubricate table support rod (see **Page 44**).

After 50 Hours of Use:

- Check and correct V-belt tension, damage, or wear (see **Page 47**).
- Check and correct sanding belt tension (see **Page 48**).

Yearly

- Check and lubricate the rocker plate (see **Page 44**).

Cleaning

Cleaning the Model G1014Z/G1014ZX is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 41** for more details).

Lubrication

An essential step for lubrication is cleaning the components before lubricating them.

This idea is critical because dust will build up on lubricated components and make them hard to move. Simply adding more grease to the components with built-up grime on them will not yield smooth moving components.

Clean the components in this section with an oil/grease solvent cleaner, such as shown on **Page 17** so they move smoothly.

The following components need to be lubricated:

- Rocker Plate
- Table Support Rod



Table Support Rod

Lubricant	Frequency	Qty
Light Machine Oil	Monthly	Thin Coat

Use a shop rag and mineral spirits to wipe away any built up grime and debris off of the table support rod, then brush on a thin coat of light machine oil onto the shaft (see **Figure 86**). Move the work table back and forth to distribute the oil.



Figure 86. Table support rod lubrication.

Rocker Plate

Lubricant	Frequency	Qty
NLGI #2 Grease	Yearly	Dollop

Clean the rocker plate with mineral spirits and a rag, and brush a dollop of grease onto the rocker plate. Move the quick release tension lever forward and backward to spread the grease (see **Figure 87**).

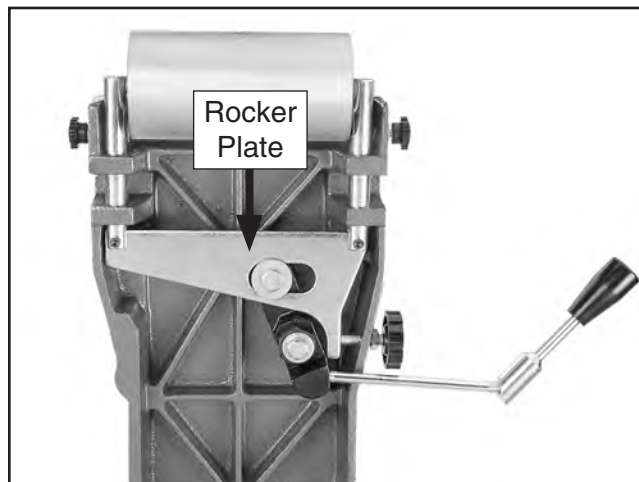


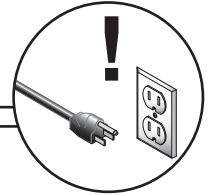
Figure 87. Rocker plate lubrication.



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Switch disabling key removed. 2. Motor cord not connected to power cord (G1014ZX only). 3. Power supply switched OFF or at fault. 4. Plug/receptacle at fault/wired wrong. 5. Motor connection wired wrong. 6. Wall circuit breaker tripped. 7. Wiring open/has high resistance. 8. Start capacitor at fault. 9. Motor ON/OFF switch at fault. 10. Motor at fault. 	<ol style="list-style-type: none"> 1. Install switch disabling key. 2. Connect motor cord to power cord (G1014ZX). 3. Ensure power supply is on/has correct voltage. 4. Test for good contacts; correct the wiring. 5. Correct motor wiring connections. 6. Ensure circuit size is correct/replace weak breaker. 7. Check/fix broken, disconnected, or corroded wires. 8. Test/replace if faulty. 9. Replace switch. 10. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Feed rate too aggressive. 2. Machine undersized for task. 3. Workpiece material not suitable for machine. 4. Belt slipping. 5. Motor wired incorrectly. 6. Pulley slipping on shaft. 7. Plug/receptacle at fault. 8. Motor bearings at fault. 9. Motor overheated. 10. Motor at fault. 	<ol style="list-style-type: none"> 1. Decrease feed rate. 2. Clean/replace sandpaper; reduce feed rate/sanding depth. 3. Only sand wood, ensure moisture is below 20%. 4. Tension/replace belt; ensure pulleys are aligned. 5. Wire motor correctly. 6. Replace loose pulley/shaft. 7. Test for good contacts/correct wiring. 8. Test/repair/replace. 9. Clean motor, let cool, and reduce workload. 10. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. V-belt worn or loose. 3. Workpiece loose. 4. Pulley loose. 5. Incorrectly mounted to workbench. 6. Motor fan rubbing on fan cover. 7. Motor mount loose/broken. 8. Sanding disc out of balance or loose. 9. Motor bearings at fault. 10. Work table support rod rubbing on motor. 	<ol style="list-style-type: none"> 1. Inspect/replace damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Inspect/replace belt. 3. Use the correct holding fixture and reclamp workpiece. 4. Realign/replace shaft, pulley, setscrew, and key. 5. Adjust feet, shim, or tighten mounting hardware. 6. Fix/replace fan cover; replace loose/damaged fan. 7. Tighten/replace. 8. Tighten disc hub or replace disc. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 10. Adjust table support rod.



Machine Operation

Symptom	Possible Cause	Possible Solution
Machine vibrates excessively.	<ol style="list-style-type: none"> 1. Sander not secured properly to stand (G1014Z) or cabinet (G1014ZX). 2. Stand not stable on floor. 3. Incorrect motor mounting. 4. Idler roller is too loose. 5. Broken/defective sanding belt. 6. End of table support rod touches side of motor. 	<ol style="list-style-type: none"> 1. Tighten fasteners that mount sander to stand (G1014Z) or cabinet (G1014ZX). 2. Secure stand to floor, reposition to level surface, or shim stand. 3. Check/adjust motor mounting. 4. Adjust idler roller. 5. Replace sanding belt (see Page 39). 6. Position the table support rod further away from motor.
Sanded surface not square.	<ol style="list-style-type: none"> 1. Work table not perpendicular to disc. 2. Miter gauge not square to disc. 3. Work table not perpendicular to belt in vertical position. 	<ol style="list-style-type: none"> 1. Adjust work table square to sanding disc (see Page 49). 2. Adjust miter gauge square to disc or belt (Page 27). 3. Adjust work table square to belt in vertical position (see Page 37).
Deep sanding grooves or scars in workpiece.	<ol style="list-style-type: none"> 1. Sandpaper too coarse for the desired finish. 2. Workpiece sanded across the grain. 3. Too much sanding force on workpiece. 4. Workpiece held still against the belt/disc. 	<ol style="list-style-type: none"> 1. Use a finer grit sanding belt/disc. 2. Sand with the grain. 3. Reduce pressure on workpiece while sanding. 4. Keep workpiece moving while sanding on the belt/disc.
Grains rub off the belt or disc easily.	<ol style="list-style-type: none"> 1. Sanding belt/disc has been stored in an incorrect environment. 2. Sanding belt/disc has been folded or smashed. 	<ol style="list-style-type: none"> 1. Store sanding belt/disc away from extremely dry or hot temperatures. 2. Store sanding belt/disc flat, not folded or bent.
Sanding surfaces clog quickly or burn.	<ol style="list-style-type: none"> 1. Too much pressure against belt/disc. 2. Sanding softwood, or stock has surface residue. 	<ol style="list-style-type: none"> 1. Reduce pressure on workpiece while sanding. 2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning or replacing belts or discs frequently.
Burn marks on workpiece.	<ol style="list-style-type: none"> 1. Using too fine of sanding grit. 2. Using too much pressure. 3. Work held still for too long. 	<ol style="list-style-type: none"> 1. Use a coarser grit sanding belt/disc. 2. Reduce pressure on workpiece while sanding. 3. Do not keep workpiece in one place for too long.
Glazed sanding surfaces.	<ol style="list-style-type: none"> 1. Sanding wet stock. 2. Sanding stock with high residue. 	<ol style="list-style-type: none"> 1. Dry stock properly before sanding. 2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/replacing belts/discs frequently.
Workpiece frequently gets pulled out of your hand.	<ol style="list-style-type: none"> 1. Not supporting the workpiece against the stop. 2. Starting the workpiece on a leading corner. 	<ol style="list-style-type: none"> 1. Use back stop or miter gauge to support workpiece. 2. Start workpiece on a trailing corner.
Belt slips on rollers.	<ol style="list-style-type: none"> 1. Quick release tension lever not engaged. 2. Belt tension not sufficient. 	<ol style="list-style-type: none"> 1. Engage quick release tension lever. 2. Adjust belt tension (see Page 48)



V-Belt Tension & Replacement

The V-belt is pre-installed and tensioned at the factory. However, we recommend you verify this setting and also check the V-belt tension after the first 16 hours of operation, during which the belt will stretch and seat.

Tools Needed	Qty
Hex Wrench 4mm.....	1
Wrench 12mm	1

Tensioning V-Belt

1. DISCONNECT SANDER FROM POWER!
2. Remove the work table assembly from the sanding disc, then open the pulley cover.
3. While looking through the access hole on the side of the pulley cover (see **Figure 29** on **Page 23**), rotate the cast iron plate and loosen each of the set screws that secure the plate to the drive shaft.
4. Remove the cast iron plate to expose the V-belt.
5. Push the center of the V-belt with your finger to check belt tension. The belt is correctly tensioned when there is approximately $\frac{1}{4}$ " deflection when it is pushed with moderate pressure, as shown in **Figure 88**.

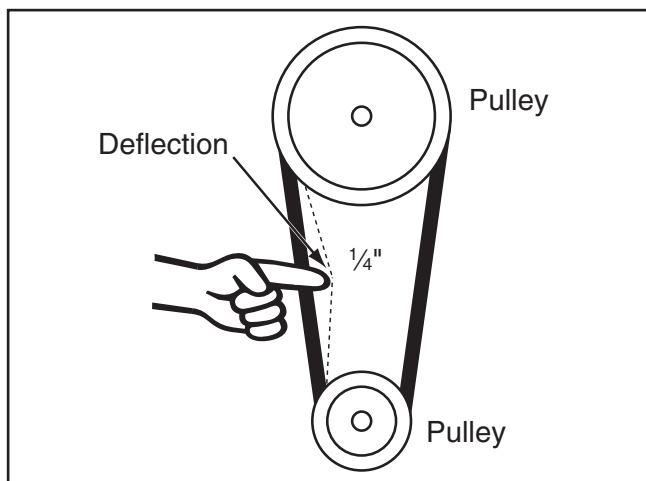


Figure 88. Checking belt tension.

—If there is approximately $\frac{1}{4}$ " deflection, no adjustments are necessary. Go to **Step 9**.

—If there is more or less than that $\frac{1}{4}$ " deflection when you push the V-belt with moderate pressure, follow **Steps 6-7**.

6. Loosen the four hex bolts that secure the motor to the base, as shown in **Figures 89–90**, then slide the motor toward the back of the sander to reduce belt tension or slide it toward the front of the sander to increase tension.

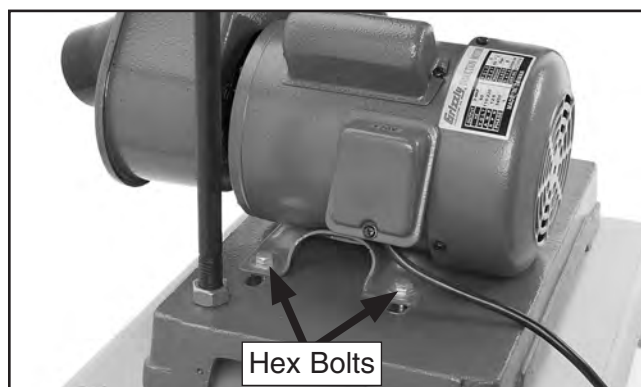


Figure 89. Rear motor mounting bolts.

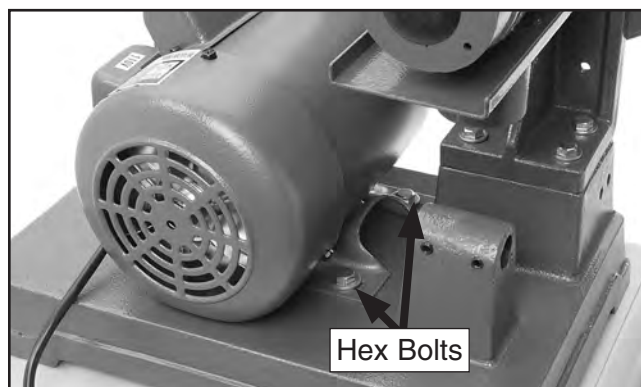


Figure 90. Front motor mounting bolts.

7. Tighten the four hex bolts to secure the motor.
8. Repeat **Step 5** and re-adjust the V-belt tension if necessary.
9. Re-install the cast iron plate onto the drive shaft and secure with the set screws, close and secure the pulley cover, then re-install the work table.



Replacing V-Belt

1. DISCONNECT SANDER FROM POWER!
2. Follow **Steps 2-4** in **Tensioning V-Belt** on **Page 47**.
3. Loosen the four hex bolts that secure the motor to the base, as shown in **Figures 89–90**, then slide the motor toward the back of the sander to reduce belt tension.
4. Remove the V-belt and replace it with a new one.
5. Slide the motor toward the front of the sander, then tighten the four hex bolts on the motor base.
6. Repeat **Step 5** on **Page 47** and adjust the V-belt tension as needed.
7. Re-install the cast iron plate onto the drive shaft and secure it with the two set screws, close and secure the pulley cover, then re-install the work table.

3. Loosen the hex bolt on the eccentric (see **Figure 91**).

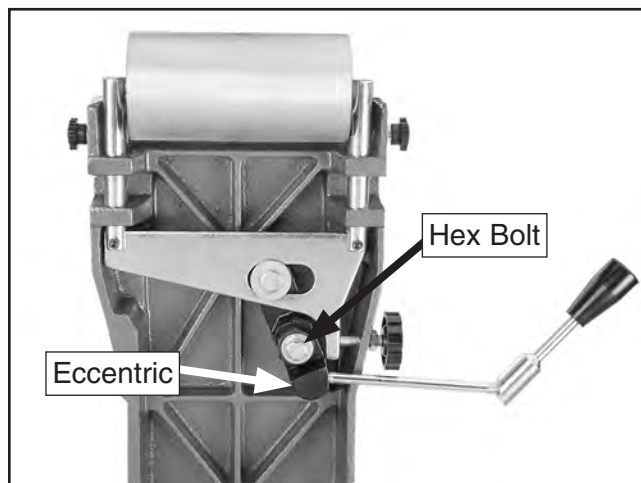


Figure 91. Location of belt tension adjustments (belt removed for clarity).

4. Turn the eccentric to the left to tighten the belt or right to loosen the belt tension, then tighten the hex bolt on the eccentric.
5. Push the belt in the center with your finger using moderate pressure. The deflection is correct when the belt deflects $\frac{1}{2}$ ", as shown in **Figure 92**.

Sanding Belt Tension

Correct belt tension will ensure that your sander functions properly. If the sanding belt slaps against the platen or slips on the idler and drive rollers, the belt may be too loose. If you have a difficult time installing a new sanding belt, tension may be too tight.

Tools Needed	Qty
Wrench 14mm	1
Adjustable Wrench w/ $1\frac{1}{2}$ " Throat.....	1

To adjust sanding belt tension:

1. DISCONNECT SANDER FROM POWER!
2. Move the quick release tension lever toward the motor to tighten the sanding belt.

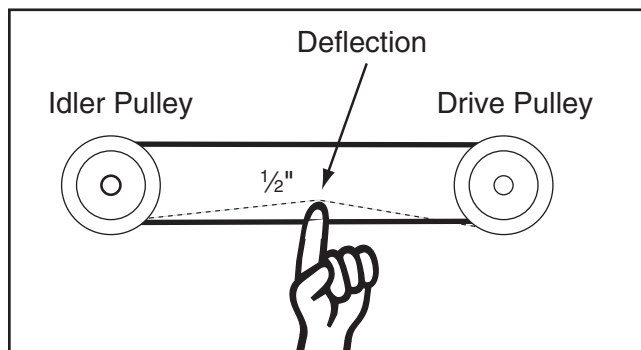


Figure 92. Checking sanding belt tension.

6. Follow the **Pre-Tracking Belt** instructions on **Page 27**.
7. Turn the sander **ON** and check the belt tracking. If the belt does not stay in the center of the idler and drive rollers, adjust the tracking with the tracking control knob (refer to **Tracking Belt** on **Page 40** for further detail).



Pulley Alignment

Proper pulley alignment prevents premature belt wear. The pulleys are properly aligned when they are parallel and in the same plane as each other.

Tools Needed	Qty
Hex Wrench 4mm.....	1
Straightedge 12".....	1
Standard Screwdriver.....	1

To check and adjust pulley alignment:

1. DISCONNECT SANDER FROM POWER!
2. Remove the work table assembly and miter gauge.
3. Open the pulley cover.
4. Loosen the set screws that secure the cast iron plate to the drive shaft, then remove the plate.
5. Place a 12" straightedge across both pulleys, as shown in **Figure 93**.

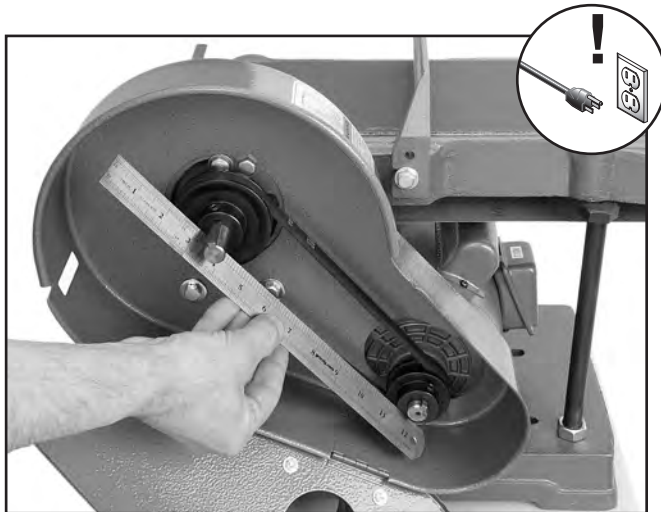


Figure 93. Checking pulley alignment.

—If the straightedge touches the pulleys evenly, no adjustments need to be made. Go to **Step 7**.

—If there is a gap between the straightedge and one of the pulleys, that pulley needs to be adjusted. Proceed to **Step 6**.

6. Loosen the set screw on the pulley where you noticed the gap, then adjust the pulley so it touches the bottom of the straightedge when it is extended across both pulleys, as shown in **Figure 93**.
7. Tighten the pulley set screw, re-install the cast iron plate, close the pulley cover, then re-install the thumb knob and work table.

Squaring Work Table to Sanding Disc

Tools Needed	Qty
Machinist's Square	1

To square the sanding disc table:

1. DISCONNECT SANDER FROM POWER!
2. Place a machinist's square or other 90° measuring tool against the work table and sanding disc (see **Figure 94**).

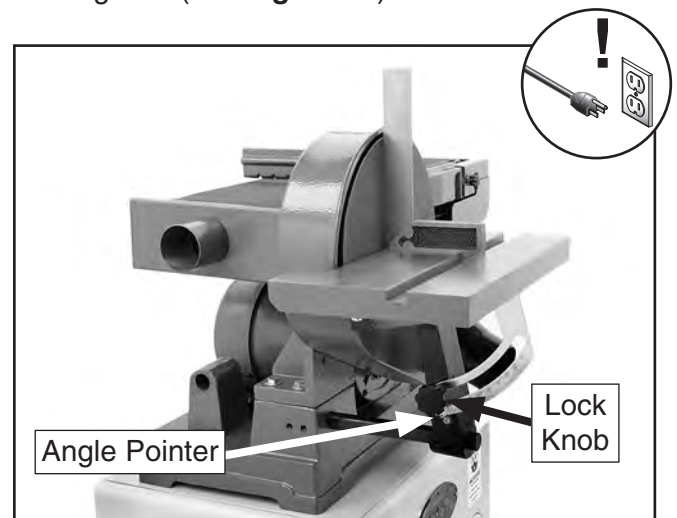


Figure 94. Using a machinist's square to adjust the work table to 90°.

3. Loosen the table lock knob, adjust the table square with the sanding disc, then re-tighten the table lock knob.
4. Loosen the Phillips head screw on the angle pointer, position the red scale pointer over the "0" mark on the angle scale, then re-tighten the screw.



Miter Slot-Disc Parallelism

If the miter slot is not parallel with the disc, workpieces may not be sanded correctly when using the miter gauge.

Tools Needed	Qty
Combination Square.....	1

To check and adjust the miter slot parallel with the sanding disc:

1. DISCONNECT SANDER FROM POWER!
2. Remove the miter gauge, then place a combination square with the 90° square in the miter slot, as shown in **Figure 95**.

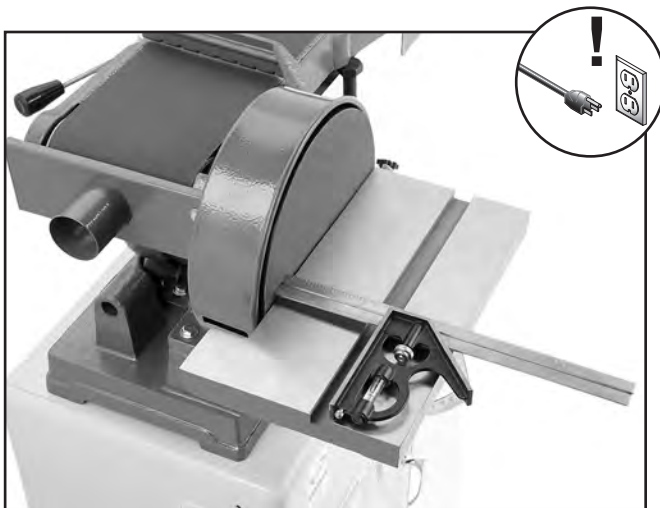


Figure 95. Checking miter slot parallelism with sanding disc.

3. Slide the square to the other side and check to see if the distance from the slot to the sanding disc is the same.

—If the distance is the same, no adjustments need to be made.

—If the distance is not the same from side to side, loosen the screws (see **Figure 69** on **Page 37**) that secure the work table arm to the work table and adjust the table so it is approximately $\frac{1}{16}$ " away from the sanding belt across its entire length.

4. Repeat **Step 3** and adjust the table as needed until the miter slot is parallel with the sanding disc on both sides.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

WARNING
















Wiring Safety Instructions

1. **SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!
2. **QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.
3. **WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.
4. **WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.
5. **MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.
6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.
7. **CAPACITORS.** Some capacitors store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on capacitors.
8. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements on **Page 12** when connecting your machine to a power source.
9. **EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



G1014Z Wiring Diagram

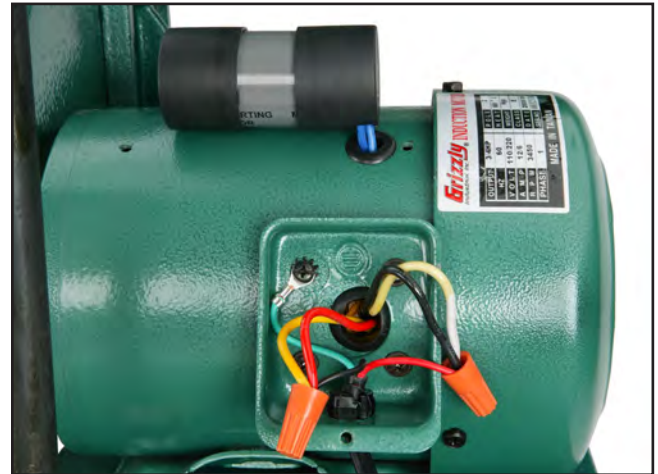
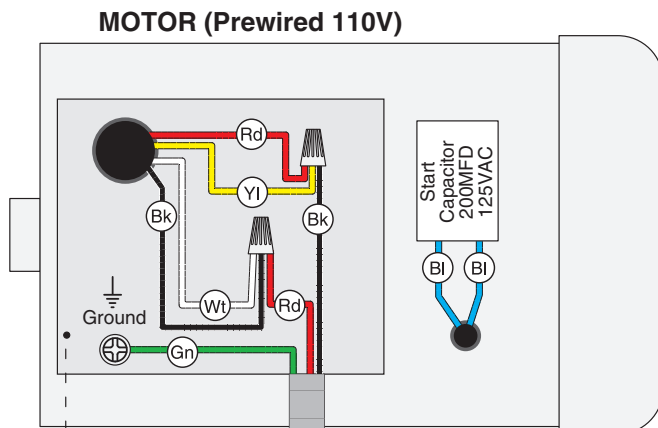


Figure 96. G1014Z motor wiring.

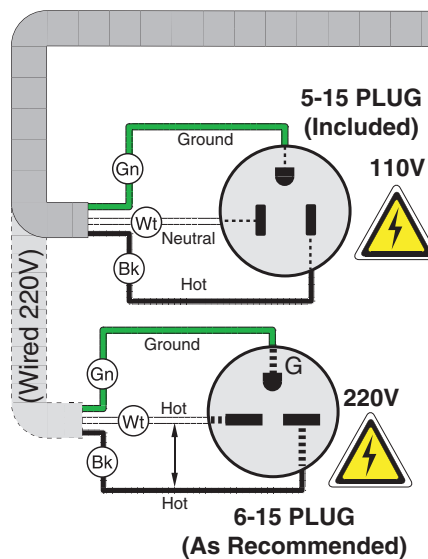
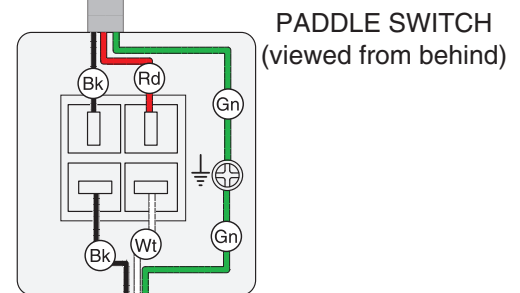
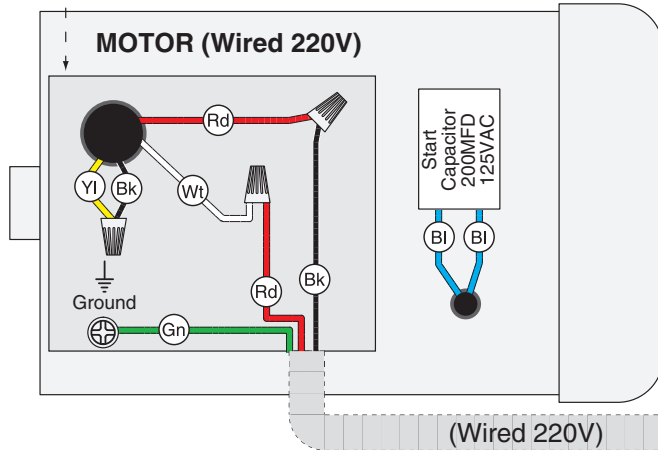


Figure 97. G1014Z switch wiring.

NOTICE
The motor wiring shown here is current at the time of printing; however, always use the diagram on the inside of junction box cover when rewiring your motor.

⚠ DANGER
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!



G1014ZX Wiring Diagram

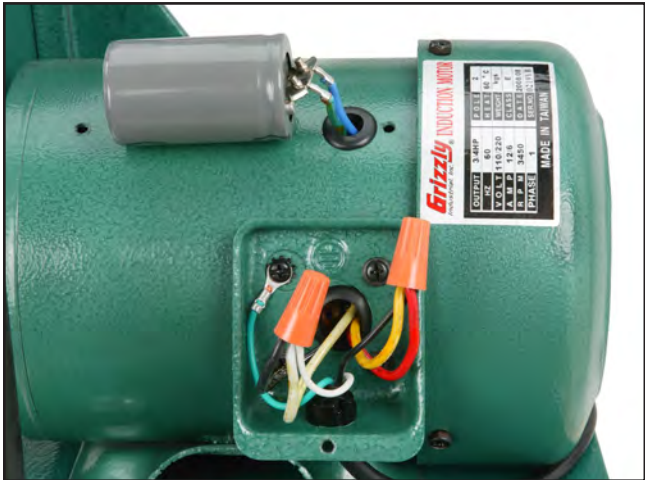
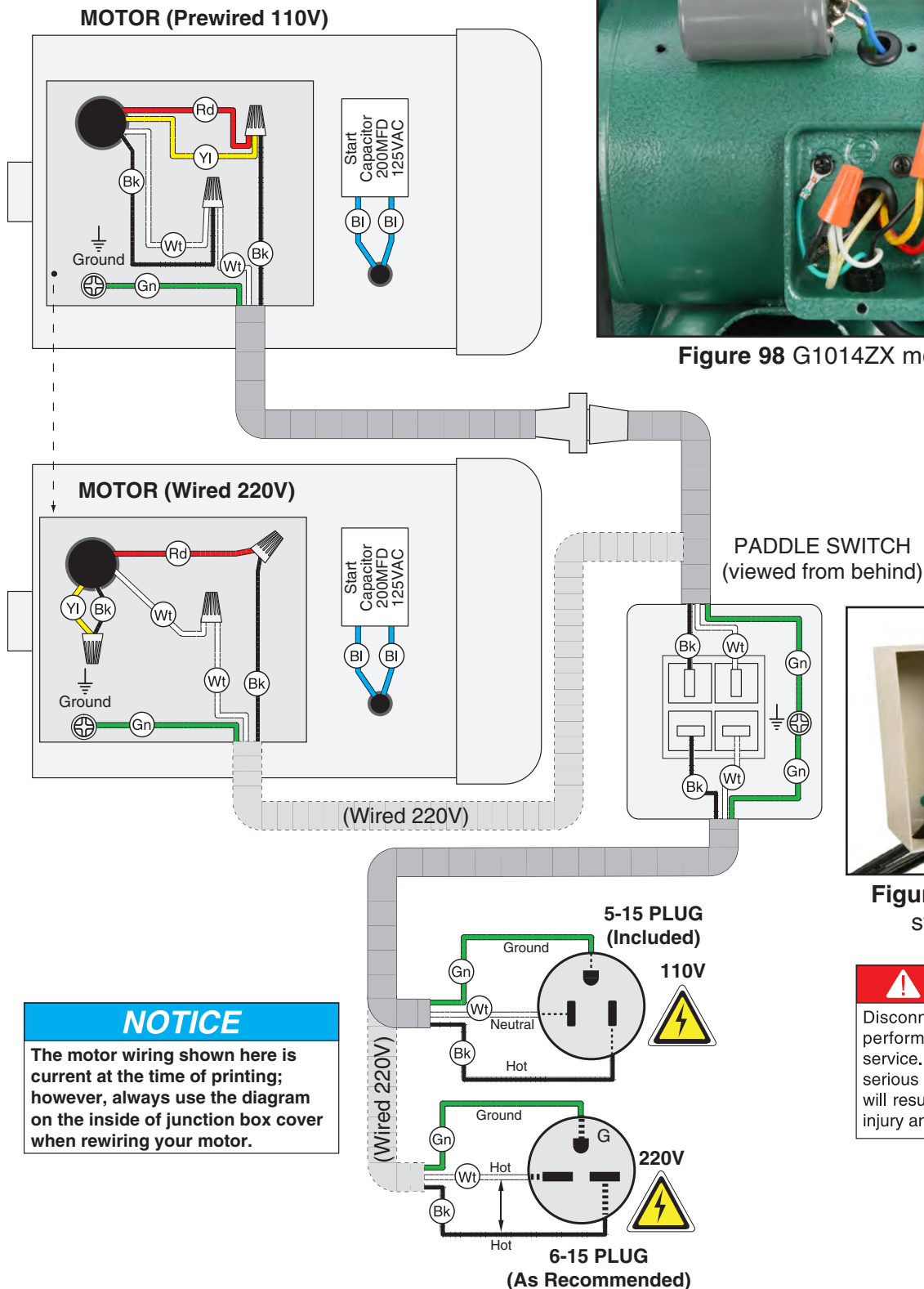


Figure 98 G1014ZX motor wiring.



Figure 99. G1014ZX switch wiring.

NOTICE

The motor wiring shown here is current at the time of printing; however, always use the diagram on the inside of junction box cover when rewiring your motor.

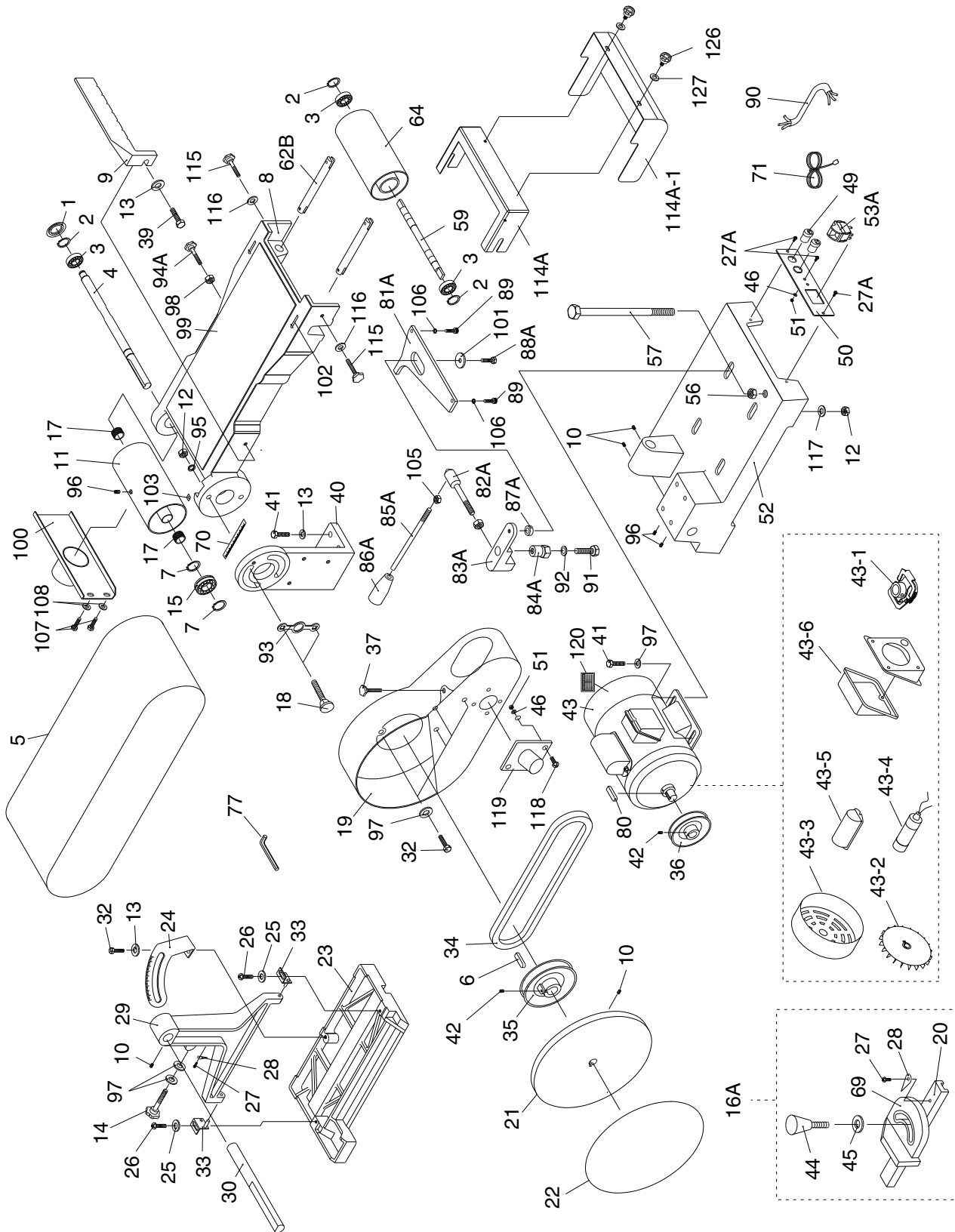
⚠ DANGER

Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!



SECTION 9: PARTS

G1014Z Main



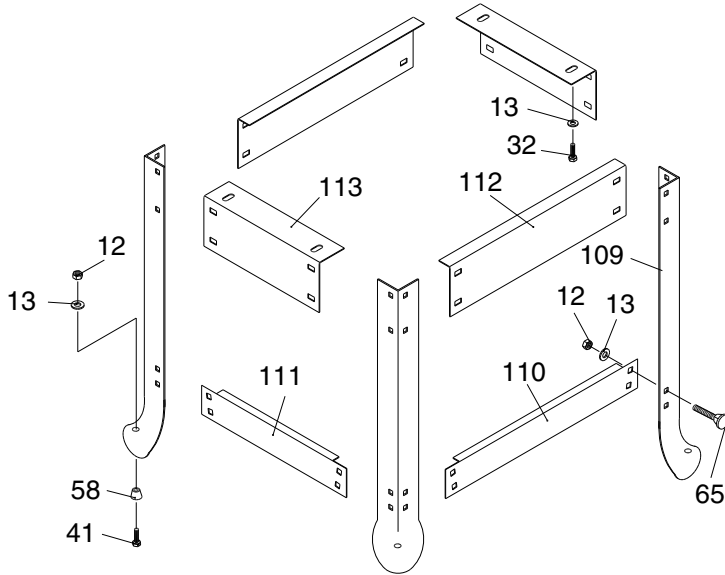
G1014Z Main Parts List

REF	PART #	DESCRIPTION
1	P1014Z001	DUST COVER
2	PR03M	EXT RETAINING RING 12MM
3	P6201-2RS	BALL BEARING 6201-2RS
4	P1014Z004	DRIVER ROLLER SHAFT
5	P1014Z005	SANDING BELT 6" X 48"
6	PK112M	KEY 5 X 5 X 55
7	PR05M	EXT RETAINING RING 15MM
8	P1014Z008	SANDING BELT FRAME
9	P1014Z009	BACK STOP
10	PSS02	SET SCREW 5/16-18 X 3/8
11	P1014Z011	DRIVE ROLLER
12	PN02	HEX NUT 5/16-18
13	PW07	FLAT WASHER 5/16
14	P1014Z014	KNOB 5/16-18
15	P6202-2RS	BALL BEARING 6202-2RS
16A	P1014Z016A	COMPLETE MITER GAUGE ASSY
17	P1014Z017	BUSHING 15 X 19.4 X 12MM
18	PCB08	CARRIAGE BOLT 5/16-18 X 1-1/2
19	P1014019A	PULLEY COVER V2.07.00
20	P1014Z020	MITER BAR
21	P1014021	CAST IRON DISC V2.02.97
22	P1014Z022	SANDING DISC PAPER 9"
23	P1014Z023	TABLE
24	P1014Z024	TRUNNION
25	PW06	FLAT WASHER 1/4
26	PS04	PHLP HD SCR 1/4-20 X 1/2
27	PS06	PHLP HD SCR 10-24 X 3/8
27A	PFS03	FLANGE SCREW 10-24 X 3/8
28	P1014Z028	POINTER
29	P1014029	TABLE SUPPORT BRACKET V2.01.98
30	P1014Z030	SUPPORT BAR
32	PB09	HEX BOLT 5/16-18 X 1/2
33	P1014Z033	TABLE MOUNT
34	PVM24	V-BELT M-24 3L240
35	P1014Z035	PULLEY
36	P1014Z036	MOTOR PULLEY
37	P1014Z037	KNOB 10-24
39	PB03	HEX BOLT 5/16-18 X 1
40	P1014040	BRACKET
41	PB03	HEX BOLT 5/16-18 X 1
42	PSS02	SET SCREW 5/16-18 X 3/8
43	P1014Z043	MOTOR 3/4 HP 110V/220V 1-PH
43-1	P1014Z043-1	CENTRIFUGAL SWITCH
43-2	P1014Z043-2	MOTOR FAN
43-3	P1014Z043-3	MOTOR FAN COVER
43-4	P1014Z043-4	S CAP 200M 125V 1-3/8 x 2-1/4
43-5	P1014Z043-5	S CAPACITOR COVER
43-6	P1014Z043-6	JUNCTION BOX COVER
44	P1014Z044	LOCK KNOB 1/4-20 X 5/8
45	P1014Z045	PLASTIC WASHER 1/4-16
46	PW03	FLAT WASHER #10
49	P1014Z049	STRAIN RELIEF

REF	PART #	DESCRIPTION
50	P1014Z050	SWITCH PLATE
51	PN07	HEX NUT 10-24
52	P1014Z052	BASE
53A	G8988	GRIZZLY SAFETY PADDLE SWITCH
56	PN04	HEX NUT 5/8-11
57	P1014Z057	HEX BOLT 5/8-11 X 9
59	P1014059B	IDLER SHAFT V3.08.97
62B	P1014Z062B	ROLLER ADJUST BAR
64	P1014064B	IDLER ROLLER V3.08.97
69	P1014Z069	MITER BODY
70	P1014Z070	TILT SCALE
71	PWRCRD110L	POWER CORD
77	PAW04M	HEX WRENCH 4MM
80	PK02M	KEY 5 X 5 X 40
81A	P1014Z081A	ROCKER PLATE
82A	P1014Z082A	SHORT LEVER
83A	P1014Z083A	ROCKER ARM
84A	P1014Z084A	ECCENTRIC
85A	P1014Z085A	LONG LEVER
86A	P1014Z086A	KNOB 3/8-16
87A	P1014Z087A	SPACER
88A	PB21	HEX BOLT 3/8-16 X 3/4
89	PSB31	CAP SCREW 10-24 X 5/8
90	P1014Z090	MOTOR CORD 16AWG x 3C
91	PB16	HEX BOLT 3/8-16 X 1-1/2
92	PW02	FLAT WASHER 3/8
93	P1014Z093	WASHER PLATE 19 X 88
94A	P1014Z094A	KNOB 3/8-24
95	PLW01	LOCK WASHER 5/16
96	PSS18	SET SCREW 5/16-18 X 3/4
97	P1014Z097	FENDER WASHER 5/16 X 21 X 2
98	PN08	HEX NUT 3/8-16
99	P1014Z099	GRAPHITE PAD 6W X 17L
100	P1014Z100	DUST PORT
101	P1014Z101	FENDER WASHER 3/8
102	P1014Z102	BELT DIRECTION ARROW
103	P1014Z103	TABLE TILT POINTER
105	PN08	HEX NUT 3/8-16
106	PLW01M	LOCK WASHER 5MM
107	PB19	HEX BOLT 1/4-20 X 1/2
108	PW06	FLAT WASHER 1/4
114A	P1014Z114A	IDLER ROLLER GUARD V2.03.08
114A-1	P1014Z114A-1	SLEEVE GUARD
115	P1014Z115	LOCK KNOB 1/4-20
116	PW06	FLAT WASHER 1/4
117	PW07	FLAT WASHER 5/16
118	PS06	PHLP HD SCR 10-24 X 3/8
119	G2977	DUST PORT (ABS) 2-1/2"
120	P1014Z120	MOTOR LABEL
126	P1014Z126	LOCK KNOB 10-32
127	PW03	FLAT WASHER #10



G1014Z Stand



REF	PART #	DESCRIPTION
12	PN02	HEX NUT 5/16-18
13	PW07	FLAT WASHER 5/16
32	PB09	HEX BOLT 5/16-18 X 1/2
41	PB03	HEX BOLT 5/16-18 X 1
58	P1014Z058	RUBBER FOOT
65	PCB01	CARRIAGE BOLT 5/16-18 X 5/8
109	P1014Z109	LEG
110	P1014Z110	LONG LOWER BRACE
111	P1014Z111	SHORT LOWER BRACE
112	P1014Z112	LONG UPPER BRACE
113	P1014Z113	SHORT UPPER BRACE

G1014Z Labels

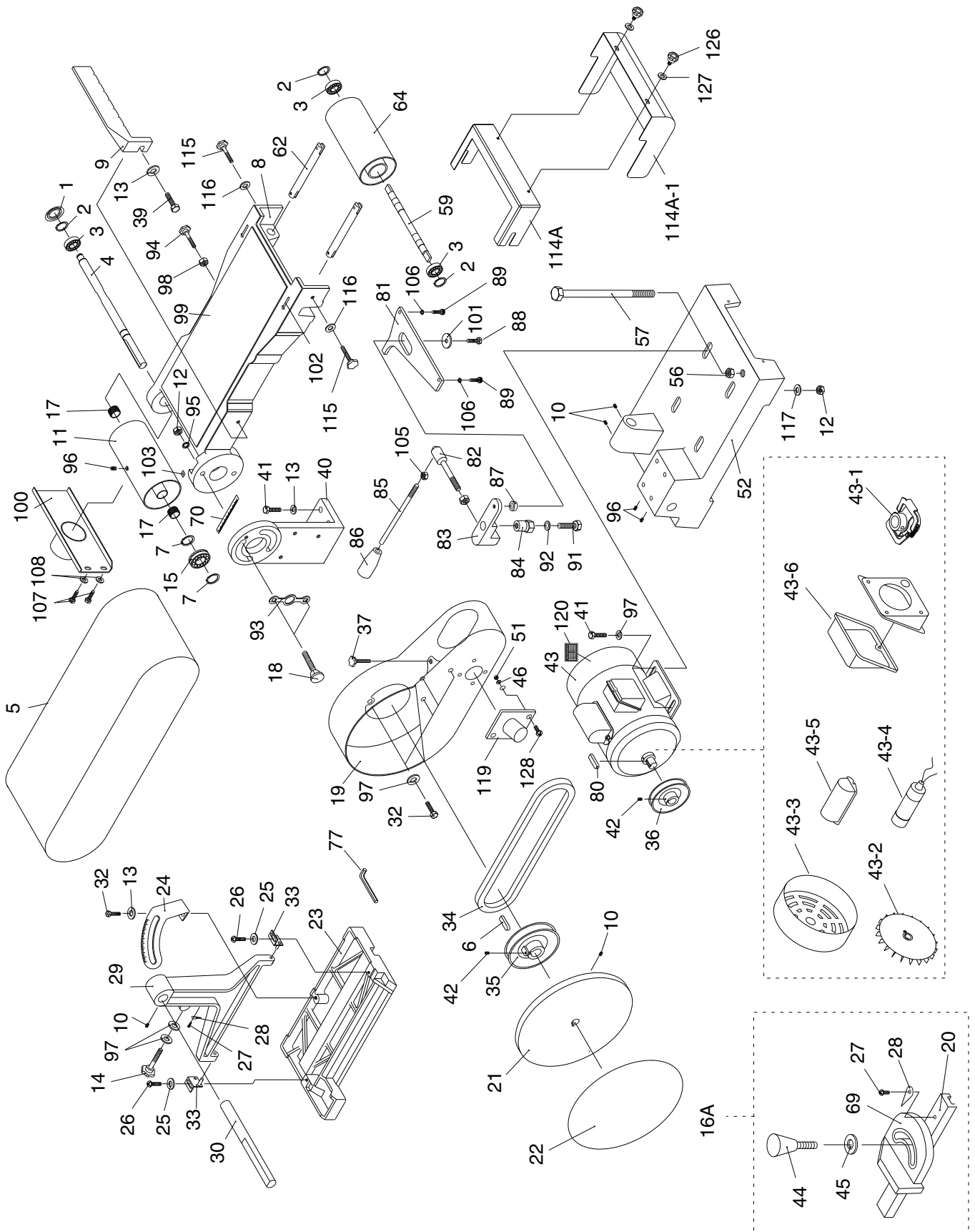


REF	PART #	DESCRIPTION
104	P1014Z104	MACHINE ID LABEL
128	P1014Z128	MODEL # LABEL G1014Z
129	PLABEL-12B	READ MANUAL 3.7W X 2H NS 7/05
130	PPAINT-1	GRIZZLY GREEN TOUCH UP PAINT
131	PPAINT-7	BLACK TOUCH UP PAINT

REF	PART #	DESCRIPTION
133	P1014Z133	ABRASION INJURY HAZARD
134	PLABEL-57	GLASSES/RESPIRATOR 2W X 3.3H
135	PLABEL-62	DISCONNECT 110V 2W X 3.3H
136	PLABEL-14B	ELECTRICITY LABEL



G1014ZX Main



G1014ZX Main Parts List

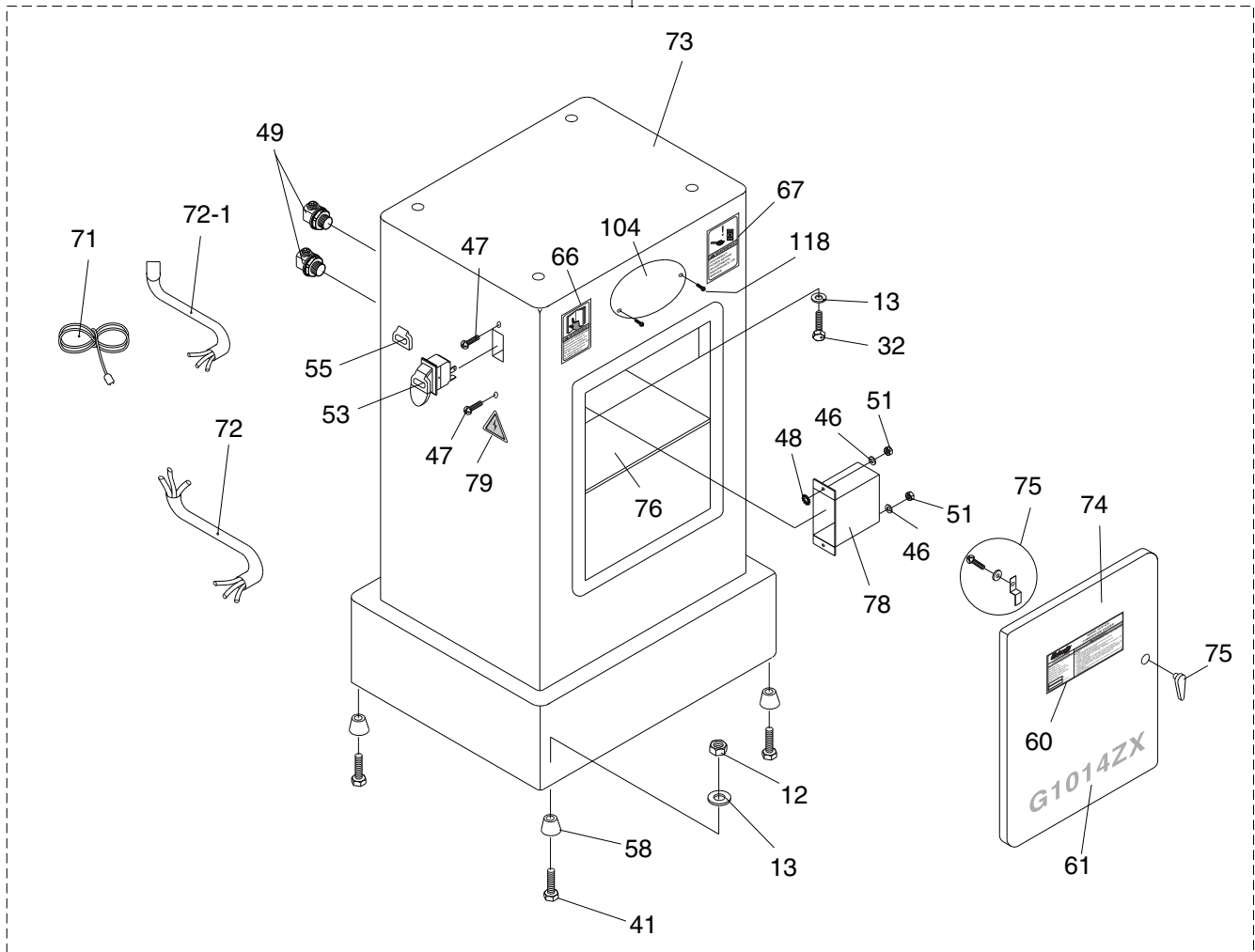
REF	PART #	DESCRIPTION
1	P1014Z001	DUST COVER
2	PR03M	EXT RETAINING RING 12MM
3	P6201-2RS	BALL BEARING 6201-2RS
4	P1014Z004	DRIVER ROLLER SHAFT
5	P1014Z005	SANDING BELT 6" X 48"
6	PK02M	KEY 5 X 5 X 40
7	PR05M	EXT RETAINING RING 15MM
8	P1014Z008	SANDING BELT FRAME
9	P1014Z009	BACK STOP
10	PSS02	SET SCREW 5/16-18 X 3/8
11	P1014Z011	DRIVE ROLLER
12	PN02	HEX NUT 5/16-18
13	PW07	FLAT WASHER 5/16
14	P1014Z014	KNOB
15	P6202-2RS	BALL BEARING 6202-2RS
16A	P1014Z016A	COMPLETE MITER GAUGE ASSY
17	P1014Z017	BUSHING 15 X 19.4 X 12MM
18	PCB08	CARRIAGE BOLT 5/16-18 X 1-1/2
19	P1014019A	PULLEY COVER V2.07.00
20	P1014Z020	MITER BAR
21	P1014021	CAST IRON DISC V2.02.97
22	P1014Z022	SANDING DISC PAPER 9"
23	P1014Z023	TABLE
24	P1014Z024	TRUNNION
25	PW06	FLAT WASHER 1/4
26	PS04	PHLP HD SCR 1/4-20 X 1/2
27	PS06	PHLP HD SCR 10-24 X 3/8
28	P1014Z028	MITER GAUGE POINTER
29	P1014029	TABLE SUPPT BRACKET V2.01.98
30	P1014Z030	SUPPORT BAR
32	PB09	HEX BOLT 5/16-18 X 1/2
33	P1014Z033	TABLE MOUNT
34	PVM24	V-BELT M-24 3L240 (QTY 1)
35	P1014Z035	PULLEY
36	P1014Z036	MOTOR PULLEY
37	P1014Z037	KNOB
39	PB03	HEX BOLT 5/16-18 X 1
40	P1014040	BRACKET
41	PB03	HEX BOLT 5/16-18 X 1
42	PSS02	SET SCREW 5/16-18 X 3/8
43	P1014Z043	MOTOR 3/4 HP 110V/220V 1-PH
43-1	P1014Z043-1	CENTRIFUGAL SWITCH
43-2	P1014Z043-2	MOTOR FAN
43-3	P1014Z043-3	MOTOR FAN COVER
43-4	P1014Z043-4	S CAP 200M 125V 1-3/8 x 2-1/4
43-5	P1014Z043-5	S CAPACITOR COVER
43-6	P1014Z043-6	JUNCTION BOX COVER
44	P1014Z044	LOCK KNOB 1/4-20 X 5/8
45	P1014Z045	PLASTIC WASHER 1/4-16

REF	PART #	DESCRIPTION
46	PW03	FLAT WASHER #10
51	PN07	HEX NUT 10-24
52	P1014Z052	BASE
56	PN04	HEX NUT 5/8-11
57	P1014Z057	HEX BOLT 5/8-11 X 9
59	P1014059B	IDLER SHAFT V3.08.97
62	P1014Z062B	ROLLER ADJ UST BAR
64	P1014064B	IDLER ROLLER V3.08.97
69	P1014Z069	MITER BODY
70	P1014Z070	SCALE
77	PAW04M	HEX WRENCH 4MM
80	PK02M	KEY 5 X 5 X 40
81	P1014Z081A	ROCKER PLATE
82	P1014Z082A	LEVER, SHORT
83	P1014Z083A	ROCKER ARM
84	P1014Z084A	ECCENTRIC
85	P1014Z085A	LONG LEVER
86	P1014Z086A	KNOB 3/8-16
87	P1014Z087A	SPACER
88	PB21	HEX BOLT 3/8-16 X 3/4
89	PSB31	CAP SCREW 10-24 X 5/8
91	PB16	HEX BOLT 3/8-16 X 1-1/2
92	PW02	FLAT WASHER 3/8
93	P1014Z093	WASHER PLATE 19 X 88
94	P1014Z094A	KNOB 3/8-24
95	PLW01	LOCK WASHER 5/16
96	PSS18	SET SCREW 5/16-18 X 3/4
97	P1014Z097	FENDER WASHER 5/16 X 21 X 2
98	PN11	HEX NUT 3/8-24
99	P1014Z099	GRAPHITE PAD 6"W X 17"L
100	P1014Z100	DUST PORT
101	P1014Z101	FENDER WASHER 3/8"
102	P1014Z102	DIRECTION SCALE
103	P1014Z103	POINTER
105	PN08	HEX NUT 3/8-16
106	PLW01M	LOCK WASHER 5MM
107	PB19	HEX BOLT 1/4-20 X 1/2
108	PW06	FLAT WASHER 1/4
114A	P1014Z114A	IDLER ROLLER GUARD V2.03.08
114A-1	P1014Z114A-1	SLEEVE GUARD
115	P1014Z115	LOCK KNOB 1/4-20
116	PW06	FLAT WASHER 1/4
117	PW07	FLAT WASHER 5/16
119	G2977	DUST PORT (ABS) 2-1/2"
120	P1014Z120	MOTOR LABEL
126	P1014Z126	LOCK KNOB 10-32
127	PW03	FLAT WASHER #10
128	PS06	PHLP HD SCR 10-24 X 3/8



G1014ZX Cabinet

73A

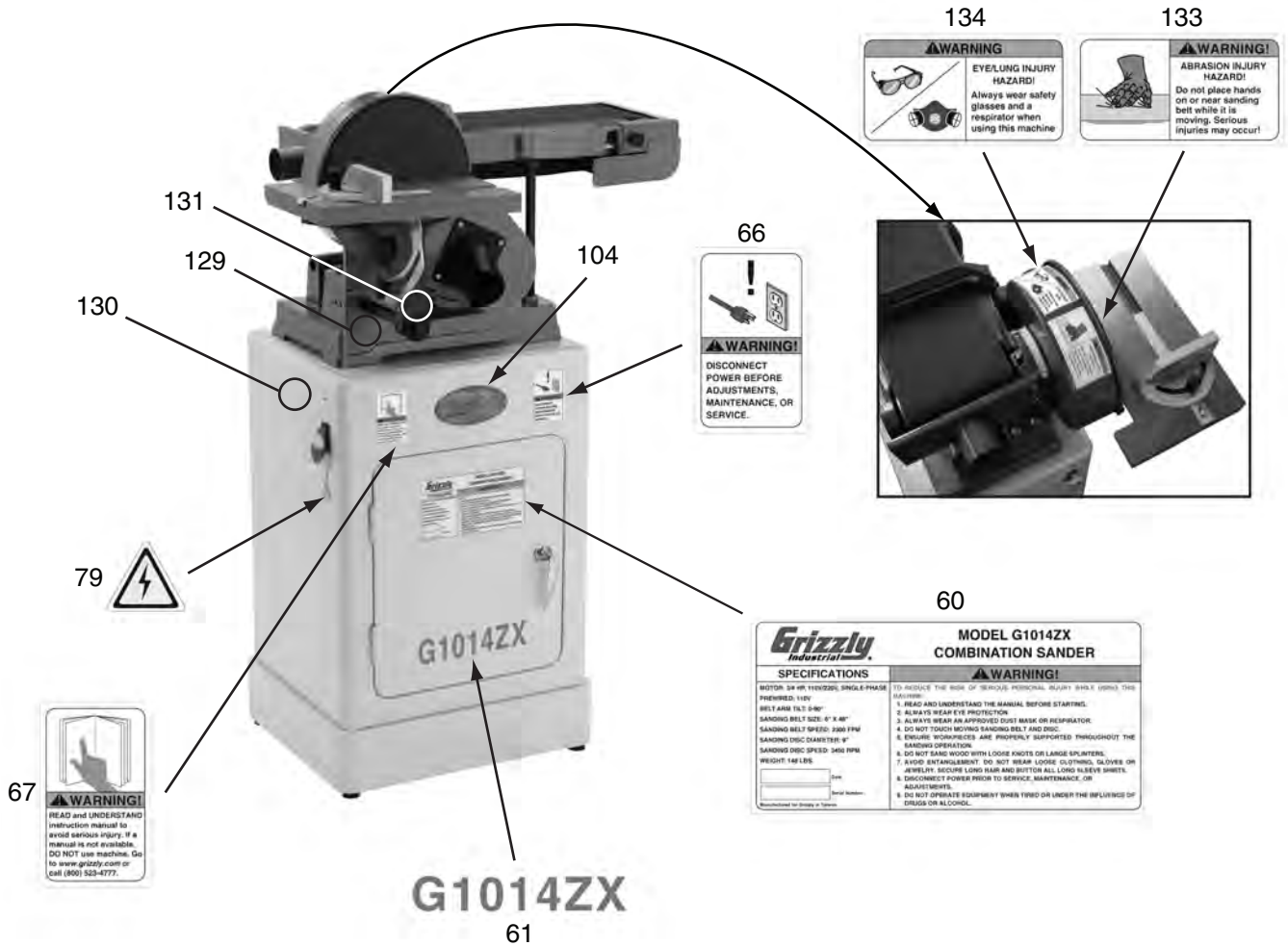


REF	PART #	DESCRIPTION
12	PN02	HEX NUT 5/16-18
13	PW07	FLAT WASHER 5/16
32	PB09	HEX BOLT 5/16-18 X 1/2
41	PB03	HEX BOLT 5/16-18 X 1
46	PW03	FLAT WASHER #10
47	PFS03	FLANGE SCREW 10-24 X 3/8
48	PTLW01	EXT TOOTH WASHER #10
49	P1014Z049	STRAIN RELIEF
51	PN07	HEX NUT 10-24
53	G8988	GRIZZLY SAFETY PADDLE SWITCH
55	PSW09-1	PADDLE SWITCH KEY
58	P1014Z058	RUBBER FOOT
60	P1014ZX060	MACHINE ID LABEL
61	P1014ZX061	MODEL # LABEL G1014ZX

REF	PART #	DESCRIPTION
66	PLABEL-62	DISCONNECT 110V 2W X 3.3H
67	PLABEL-12A	READ MANUAL V2.07.05
71	PWRCRD110L	POWER CORD
72	P1014ZX072	MOTOR CORD 1 (FEMALE)
72-1	P1014ZX072-1	MOTOR CORD 2 (MALE)
73	P1014ZX073	CABINET
73A	P1014ZX073A	COMPLETE STAND ASSY (BOX 2)
74	P1014ZX074	CABINET DOOR
75	P1014ZX075	DOOR LATCH SYSTEM
76	P1014ZX076	SHELF
78	P1014ZX078	SWITCH HOUSING
79	PLABEL-14	ELECTRICITY LABEL
104	G9987	GRIZZLY NAMEPLATE- SMALL
118	PHTEK24	TAP SCREW #5 X 3/8



G1014ZX Labels



REF PART #	DESCRIPTION
60	P1014ZX060 MACHINE ID LABEL
61	P1014ZX061 MODEL # LABEL G1014ZX
66	PLABEL-62 DISCONNECT 110V 2W X 3.3H
67	PLABEL-12A READ MANUAL V2.07.05
79	PLABEL-14 ELECTRICITY LABEL
104	G9987 GRIZZLY NAMEPLATE- SMALL

REF PART #	DESCRIPTION
129	PPAINT-1 GRIZZLY GREEN TOUCH-UP PAINT
130	PPAINT-11 GRAY PUTTY TOUCH UP-PAINT
131	PPAINT-7 BLACK TOUCH UP PAINT
133	P1014Z133 ABRASION INJURY HAZARD
134	PLABEL-57 GLASSES/RESPIRATOR 2W X 3.3H

WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.





WARRANTY CARD

Name _____
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 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

2. Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

3. What is your annual household income?

\$20,000-\$29,000 \$30,000-\$39,000 \$40,000-\$49,000
 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+

4. What is your age group?

20-29 30-39 40-49
 50-59 60-69 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value?

Yes No

8. Would you recommend Grizzly Industrial to a friend?

Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times.

Yes No

10. Comments: _____

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Name _____
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City _____ State _____ Zip _____

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WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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